

FIG. 1

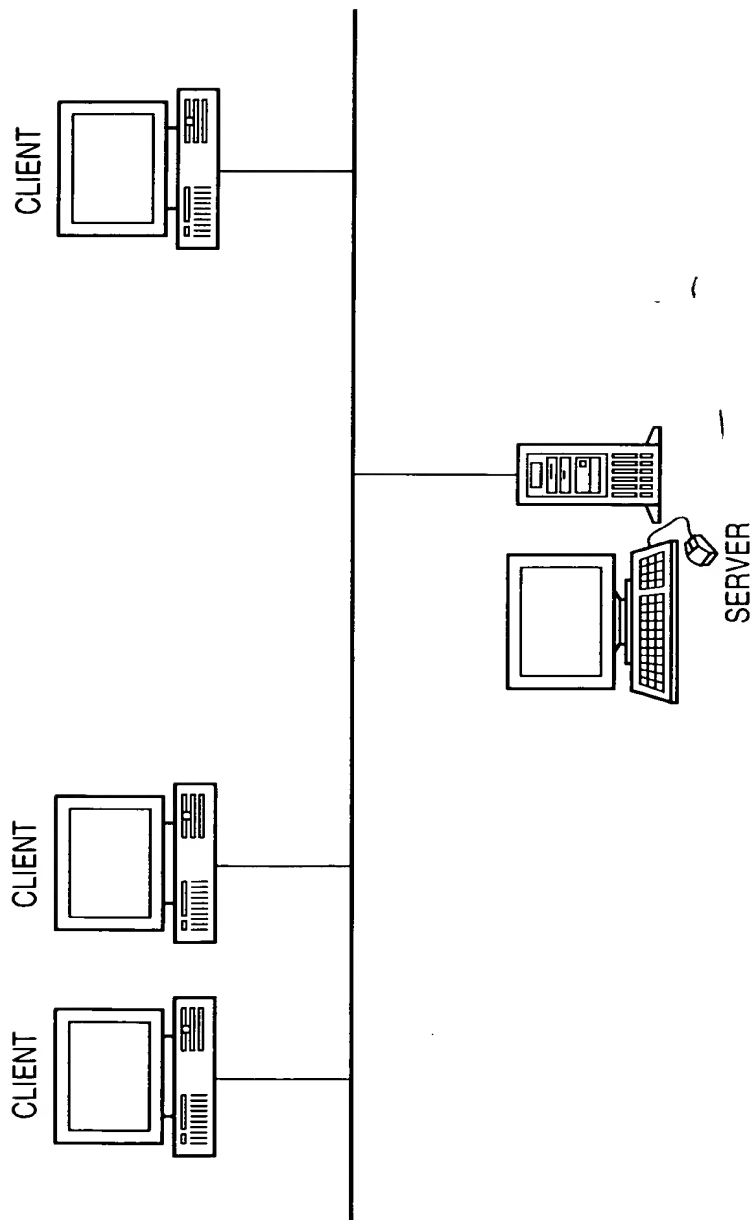
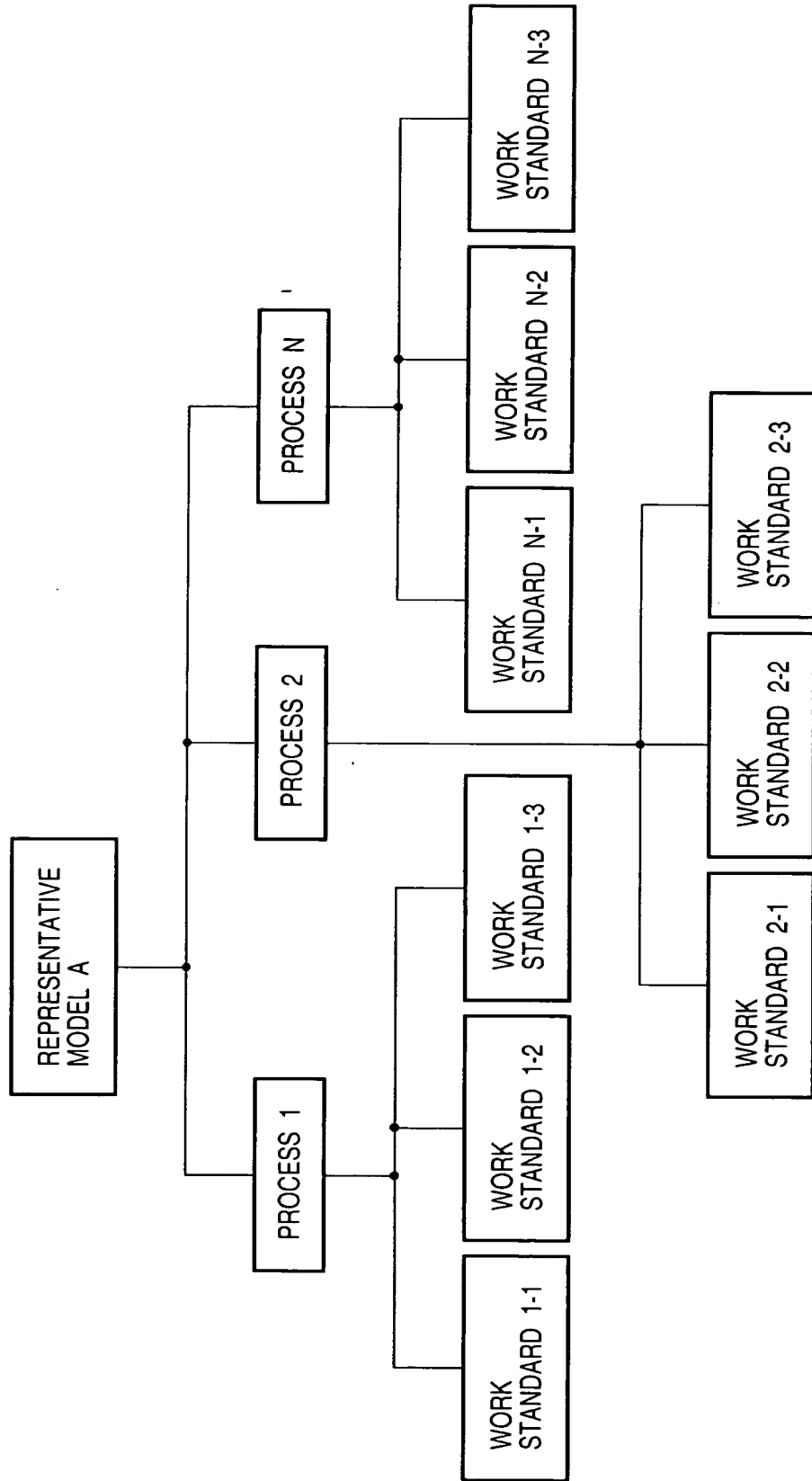


FIG. 2



3/97

FIG. 3

WORK STANDARD 01 CREATION										300																														
APPLIED										301																														
<table border="1"> <thead> <tr> <th>PART NUMBER</th> <th>PART NAME</th> <th>QUANTITY</th> <th>PART NUMBER</th> <th>PART NAME</th> <th>QUANTITY</th> </tr> </thead> <tbody> <tr> <td>303</td> <td>304</td> <td>305</td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>										PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY	303	304	305																302						
PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY																																			
303	304	305																																						
<table border="1"> <thead> <tr> <th colspan="5">TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL</th> <th>QUANTITY</th> <th>CHECK ETC.</th> </tr> </thead> <tbody> <tr> <td colspan="5">306</td> <td>307</td> <td>308</td> </tr> <tr> <td colspan="5"></td> <td></td> <td></td> </tr> <tr> <td colspan="5"></td> <td></td> <td></td> </tr> </tbody> </table>										TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL					QUANTITY	CHECK ETC.	306					307	308															303		
TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL					QUANTITY	CHECK ETC.																																		
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<table border="1"> <thead> <tr> <th>No.</th> <th>WORK PROCEDURE</th> <th>No.</th> <th>NOTE / STANDARD ETC.</th> </tr> </thead> <tbody> <tr> <td></td> <td>310</td> <td></td> <td></td> </tr> </tbody> </table>										No.	WORK PROCEDURE	No.	NOTE / STANDARD ETC.		310			309																						
No.	WORK PROCEDURE	No.	NOTE / STANDARD ETC.																																					
	310																																							
<table border="1"> <thead> <tr> <th>REVISION NUMBER</th> <th>CONTENTS OF REVISION</th> <th>DATE</th> <th>PERSON IN CHARGE</th> <th>APPROVE</th> <th>WORK NAME</th> </tr> </thead> <tbody> <tr> <td>01</td> <td>CREATED</td> <td>1997/09/25</td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>										REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME	01	CREATED	1997/09/25																						311
REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME																																			
01	CREATED	1997/09/25																																						
MANAGEMENT NO.										312																														

FIG. 4

STRUCTURE OF MASTER FILE

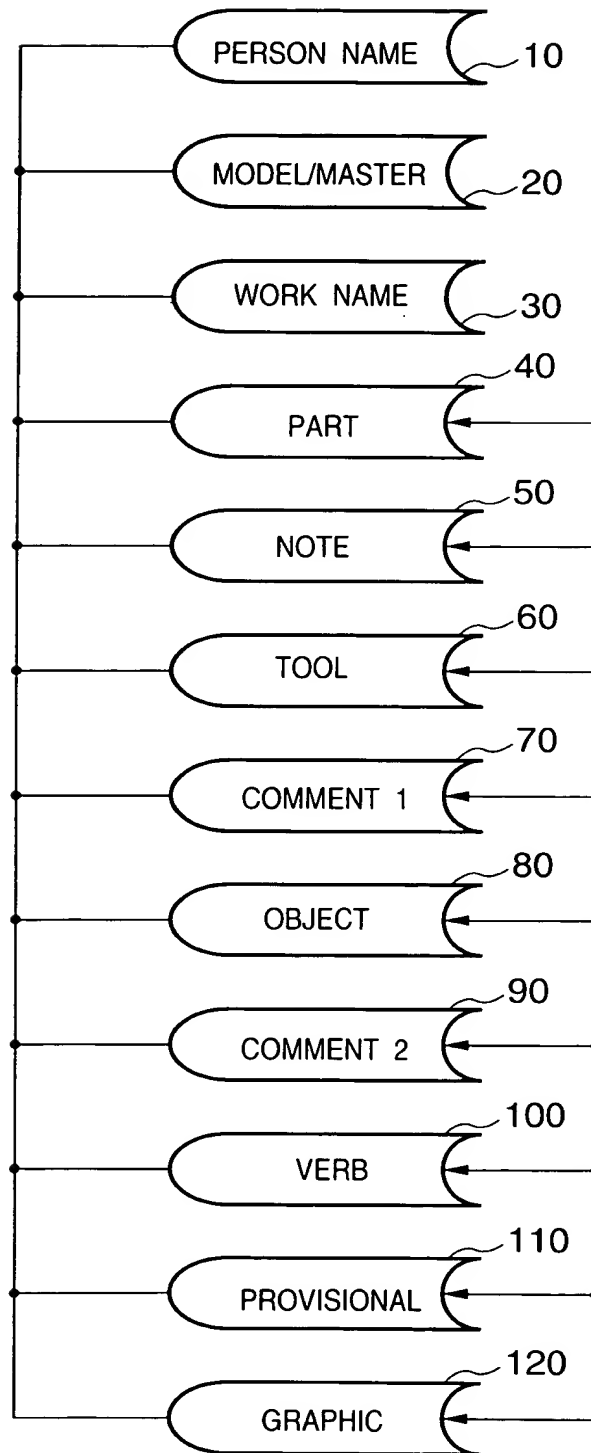


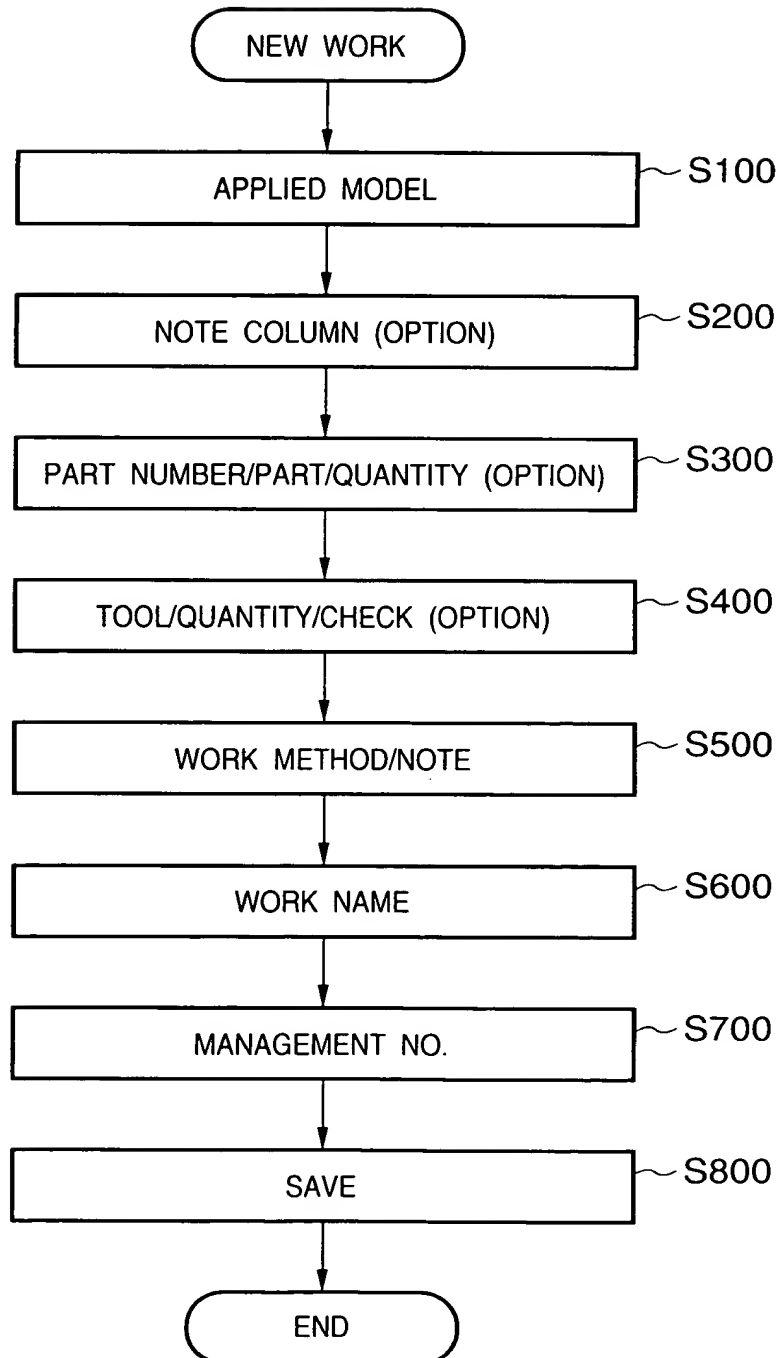
FIG. 5

FIG. 6

SELECTION OF APPLIED MODEL

LIST OF APPLIED MODELS

BJC-4200 SYSTEM

BJC-420J

BJC-420J (BLACK)

BJC-4300

BJC-430J

BJC-4200LX

A250 II Q

BJC-4200

OK

CANCEL

09753998.010301

FIG. 7

WORK STANDARD 01 CREATION					<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>			
APPLIED		BJC-420J BJC-420J(BLACK) BJC-430J									
PART NUMBER		PART NAME		QUANTITY		PART NUMBER		PART NAME		QUANTITY	

302

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101	▼	
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		

FIG. 9

• WORK NAME

GE ____

• CANDIDATES

原稿(GENKO)ガラス保護紙セット(SET ORIGINAL GLASS PROTECTIVE SHEET)

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

原稿(GENKOU)台ガラスセット(SET ORIGINAL GLASS TABLE)

原稿(GENKOU)台保護紙セット(SET ORIGINAL TABLE PROTECTIVE SHEET)

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

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FIG. 10

• WORK NAME

現像(GENZOU) __

• CANDIDATES

現像(GENZOU)レール戻しバネ掛け(HOOK DEVELOPING
RAIL RETURN SPRING)

現像(GENZOU)レール戻しバネ掛け(後)(HOOK DEVELOPING
RAIL RETURN SPRING(AFTER))

現像機(GENZOUKI)トナーなしチェック(CHECK NO TONER
IN DEVELOPER)

現像機(GENZOUKI)エラーチェック(CHECK ERROR IN
DEVELOPER)

現像機(GENZOUKI)ロック(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT) ~を

1103 (COMMENT 2)

1104 (VERB) ~する

00 ※

01

1105a

1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK CANCEL

1108

FIG. 12

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

09753998.010301

FIG. 13

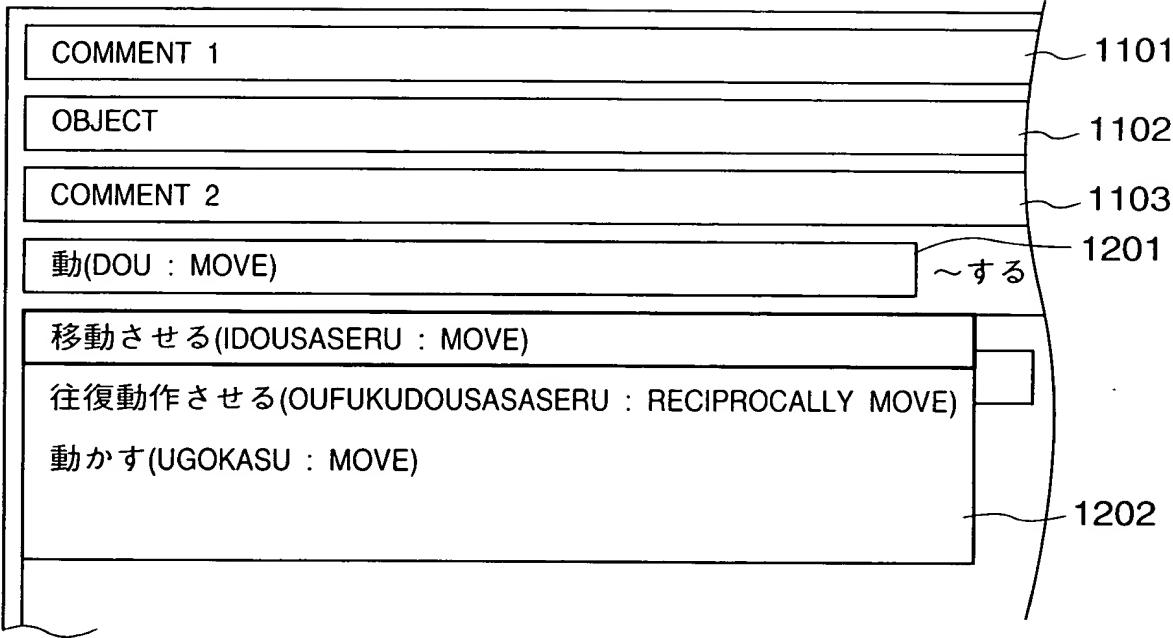


FIG. 14

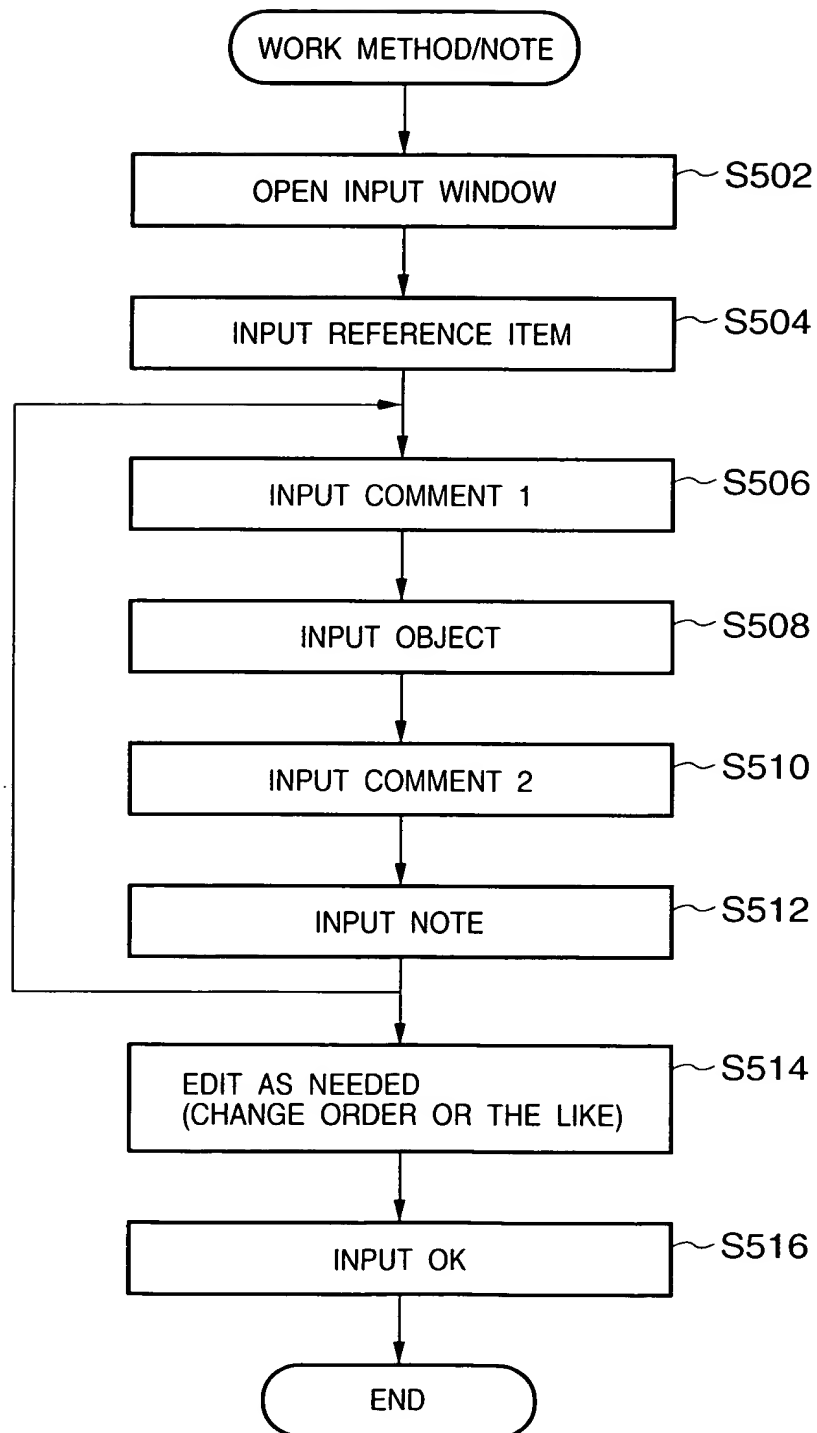


FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT www POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY

NOTE

SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu
DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE
DON'T HOOK PAPER GUIDE u ON SHEET HOLDER
BEWARE OF IMITATIONS
BEWARE OF IMITATIONS(Color Style Write

1601

1602

FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

09753998-010301

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	
02 WIND AV CORD	CUT(I)
03 SET CRG HOLDER	COPY(C)
04	PASTE(P)
	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

09753998-010301

FIG. 19

CONFIRM	～する
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

09753998-01001

FIG. 20

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	<div>CUT(<u>I</u>) COPY(<u>C</u>) PASTE(<u>P</u>) ADD(<u>A</u>) DELETE(<u>D</u>) UNDO REVISE(CHANGE) REVISE(DELETE)</div>
NOTE, STANDARD / REQUIRED QUALITY	

1802

09753998-010304

FIG. 21

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	✂ 📄 📂 ←
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

09753998-010301

FIG. 22

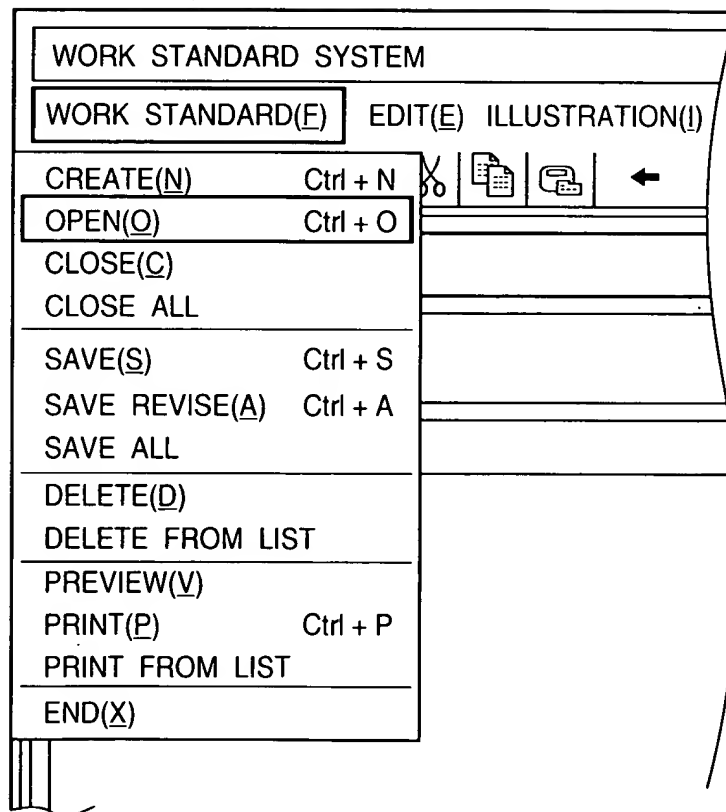


FIG. 23

23/97

WORK STANDARD SYSTEM

◎ LATEST REVISION NUMBER

○ ALL

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO-04-01(4)-E	01	ASFu取付	1997/09/13
SO-01-01(3)-E	01	ベース・トレ－u取付	1997/09/01
SO-01-03-E	01	ベース・トレ－u取付	1997/09/01
SO-01-04-E	01	ベース・トレ－u取付	1997/09/01

線処理

線処理

線処理

レールグリス塗布

レール取付





SO-06-01-E	01	線処理	1997/09/01
SO-06-02-E	01	線処理	1997/09/01
SO-06-03-E	01	線処理	1997/09/01
SO-07-01(2)-E	01	レールグリス塗布	1997/09/01
SO-08-01-E	01	レール取付	1997/09/01

OK

CANCEL

2301

FIG. 24

SYSTEM				
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)	
		VIEW(V)		
		EDIT(E)		
01 CREATE		PowerPoint		
		✓ Canvas		

09753998-010301

FIG. 25

WORK STANDARD 01 CREATION
302

APPLIED	
PART NUMBER	PART NAME
303	
TOOL / TREATMENT DEVICE	

FILE NAME :

CLOSE

CLEAR

UPDATE

2501 2502 2503 2504

No.	WORK PROCEDURE	REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME
		01	CREATED	1997/09/25			

MANAGEMENT NO.

2500

FIG. 26

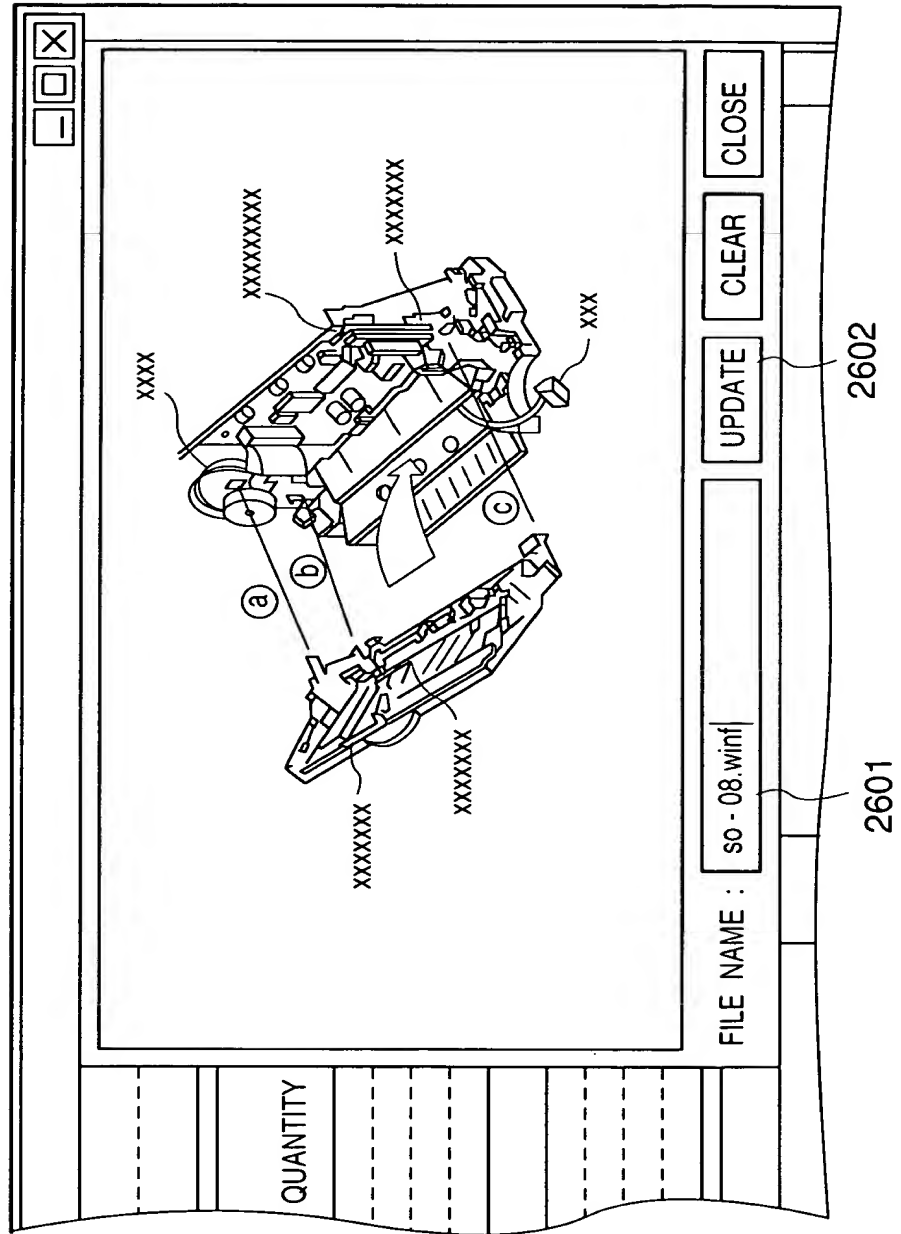
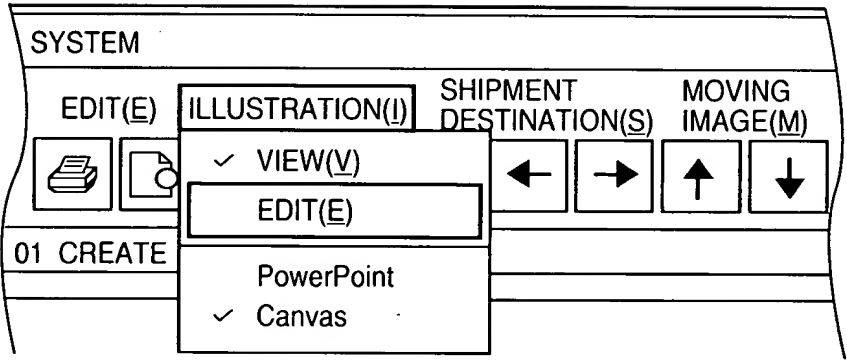
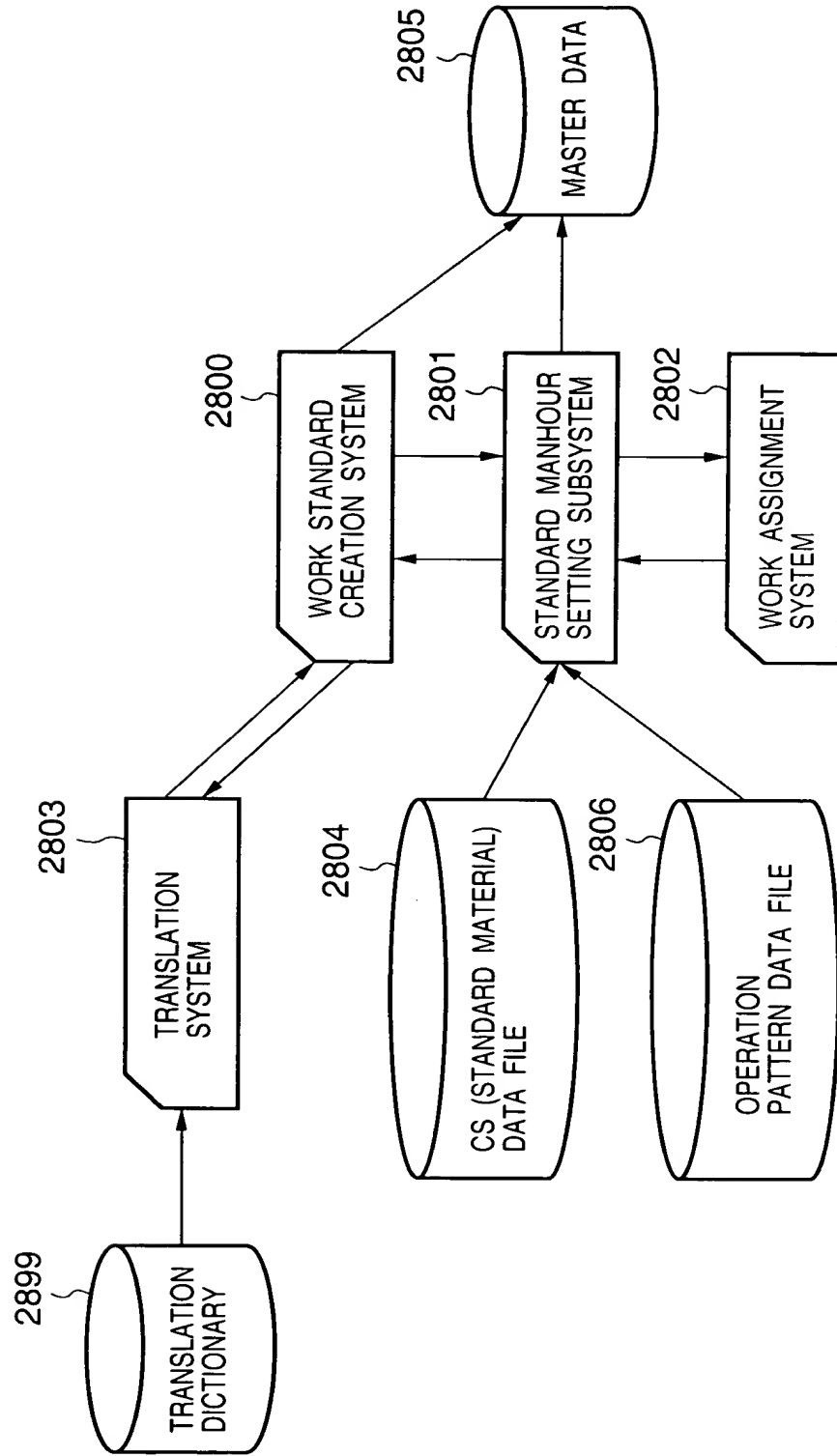


FIG. 27



09753998-010301

FIG. 28



F I G. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA

☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

TRANSLATION OF WORK STANDARD

3001 3002 3003 3004

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☒ ASSEMBLY
☐ UNIT
☐ ASSEMBLY

DISPLAY DATA
☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY LANGUAGE
☐ JAPANESE
☒ ENGLISH

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION	CHECK
PT - 010 - 010	01	クリーナu取付	X	X
PT - 010 - 020	01	クリーナu取付	X	X
PT - 010 - 030	01	クリーナu取付	X	X
PT - 070 - 030	01	切換アームAssy組立	X	X
PT - 080 - 010	01	伝達ローラu取付	X	X
PT - 090 - 010	01	伝達ローラu取付	X	X
PT - 100 - 010	01	紙押え取付	X	X

3006
3007
3008
3005

FIG. 31

[illegible]

FIG. 32

3200

3201

3202

3203

3204

WORK PROCEDURE

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける

01 ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける

02 ブレードレバ-を矢印 ② 方向にスライドさせ引っ掛かり無くハネ力で戻ることを確認する

03 ブレードレバ-軸先端がブレードホルダ-先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Side the blade lever in the direction of arrow ② and there is no catch and n....

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

TRANSLATE

OK

CANCEL

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<div><div></div><div></div><div></div></div>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S) POW(W)	
WORK STANDARD PN-030-020 01 New		PLAY(P) X2056) A252 PLATEN UNIT	
Model QG5-1317		NEW(N)	
		DRIVE(D)	

FIG. 34

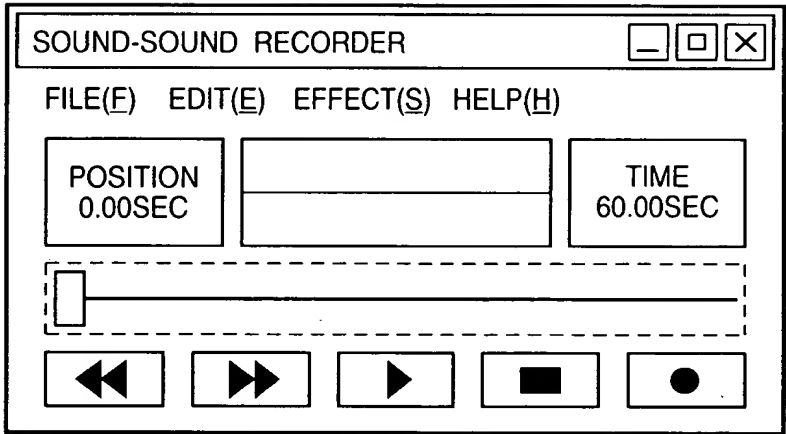


FIG. 34

FIG. 35

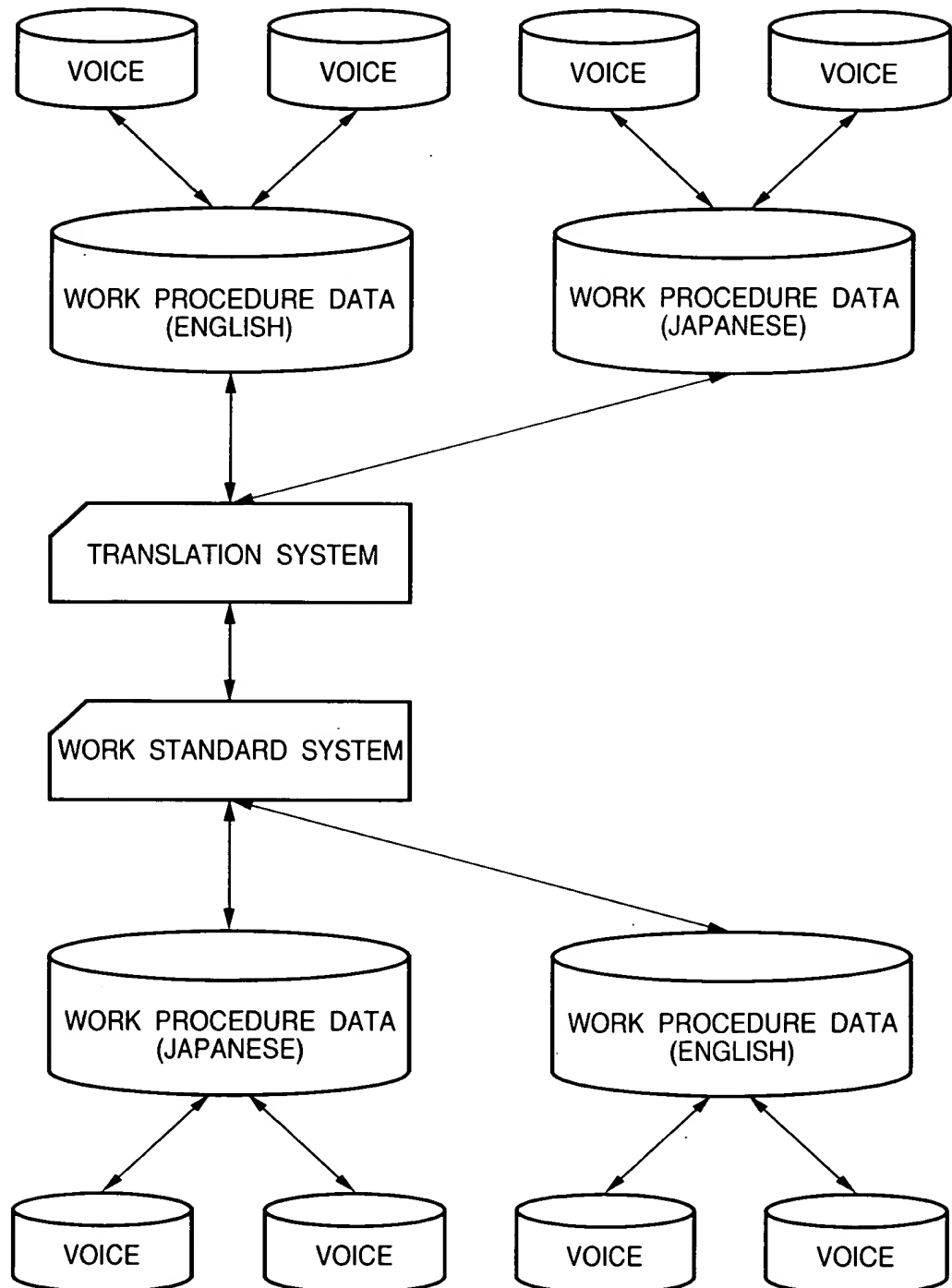


FIG. 36

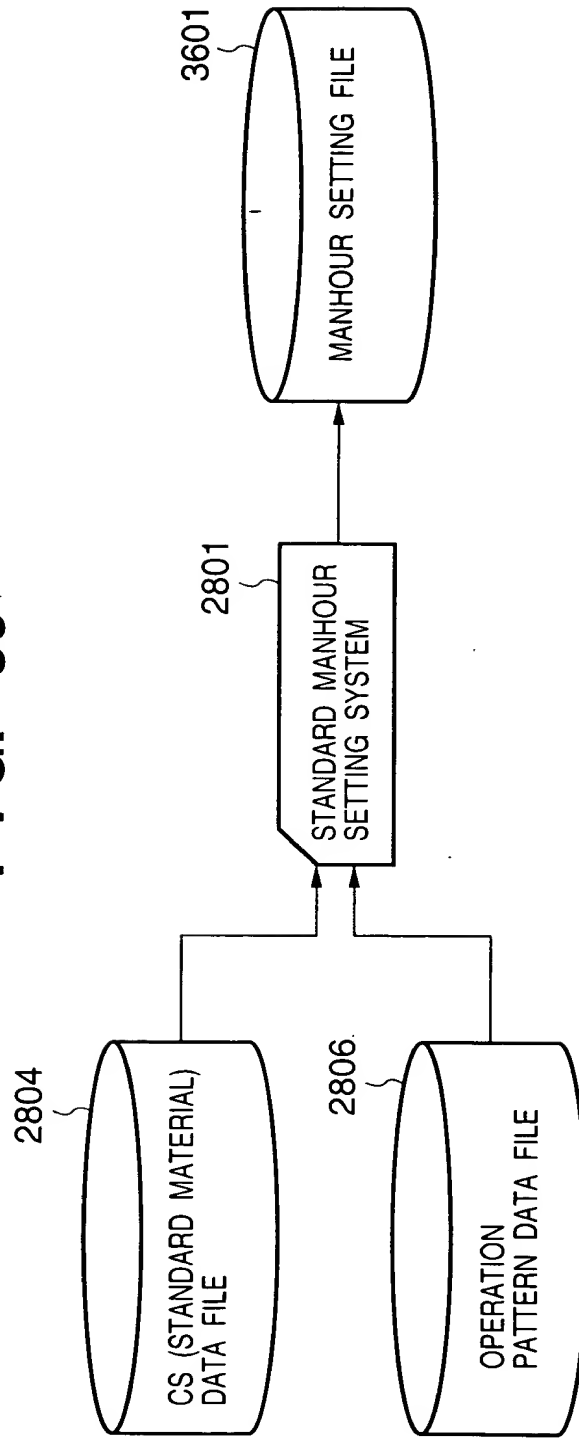


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
						1

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

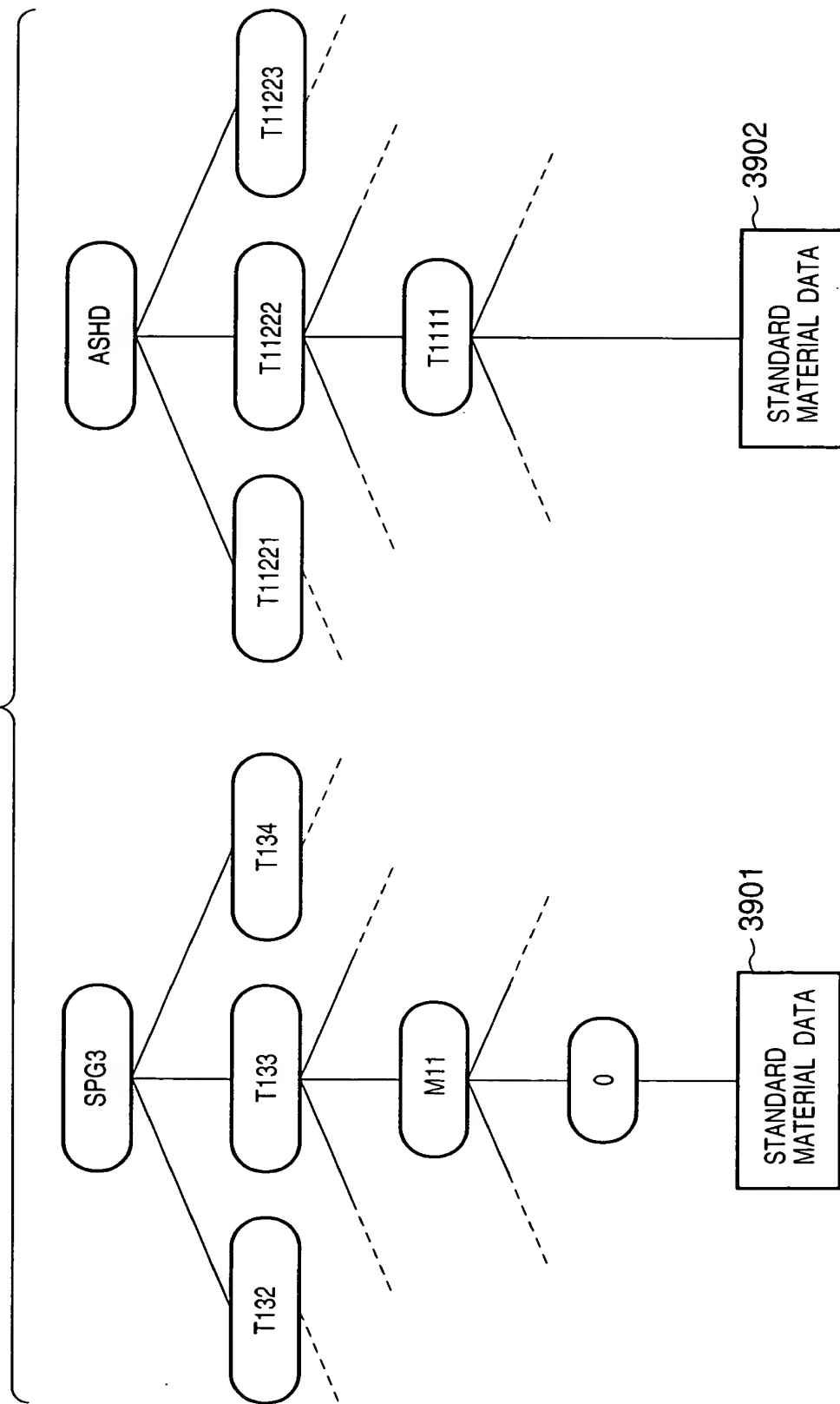


FIG. 40

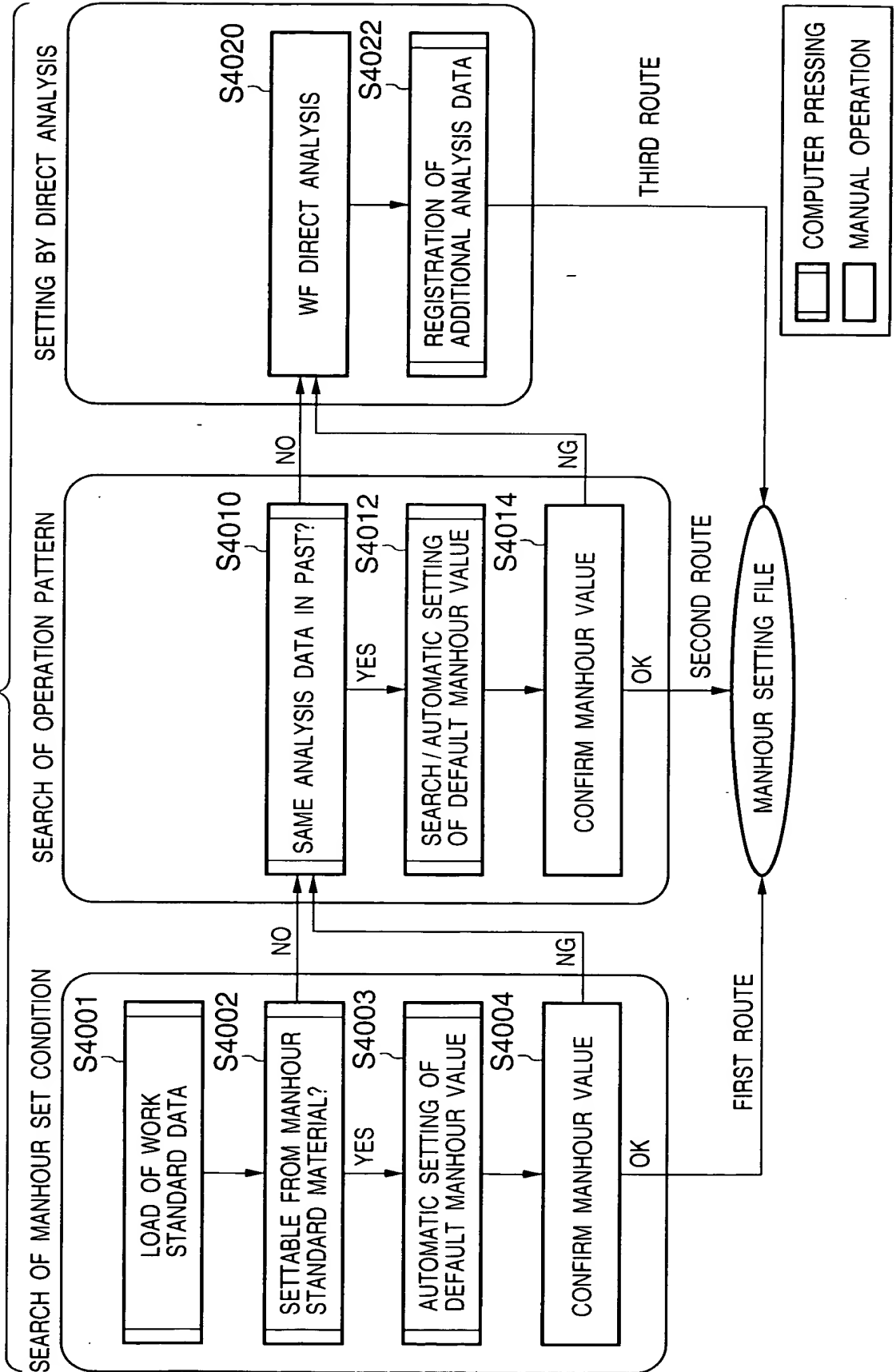


FIG. 41

3601

[illegible]

DATA LOAD

● ELEMENT WORK NAME

No.	COMMENT 1	OBJECT	COMMENT 2	VERB
1		負荷バネを	負荷バネ取付治具に	組込む
2	治具の	SWを		ONする
3		分離ロー軸を	負荷バネ取付治具に	組込む
4	治具の	SWを		OFFにする
5		分離ロー軸を	治具より	外す

FIG. 42

3601

[illegible]

/MATCH

SEARCH KEYWORD(KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	*バネを	*に	組込む	SPG3 T133 / M11 / 0	41RU
2	*	*を	*に	組込む	ASHED T11222 / T1111	37RU
3	*	*を	*より	外す	PUMQ T2111 / T111111	16RU
4	*	*エリク`を	*	組込む	RIN2 T11211 / SO	76RU
5	*	*コネクタを	*	差し込む	CONN T11211 / SO	41RU
6	*	*	*	増し締めする	SCR6 M211 / 1	23RU

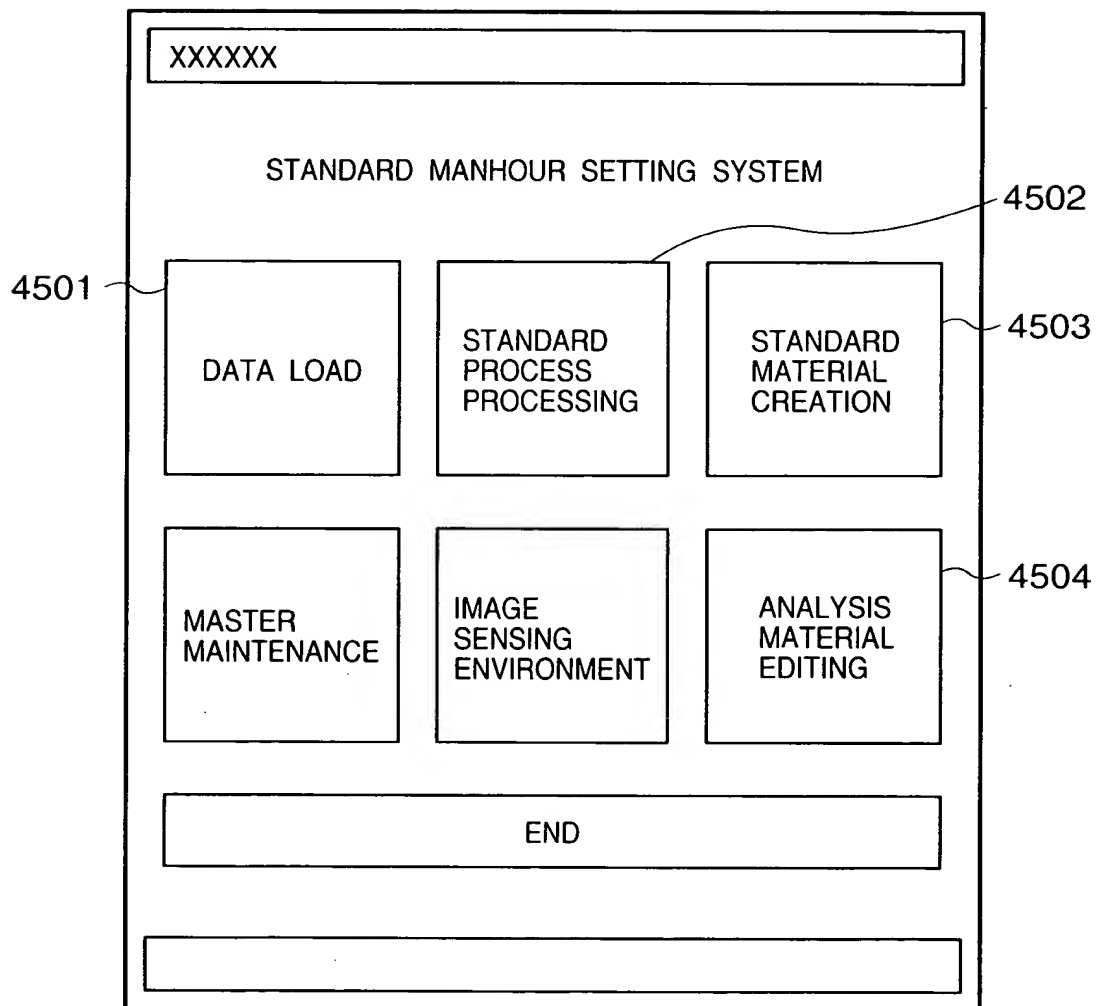
3601

[illegible]

MATCH

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	治具の	SWを		ONする	/GET:-50E/M:-10E	8RU
2	治具の	SWを		OFFする	/GET:-50E/M:-10E	8RU
3		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
4		CRGT'アを		閉める	/GET:-50E/M:-50E	10RU
5		読取操作部uを		閉める	/GET:-50E/M:-50E	10RU
6		電源コト'を		抜く	/GET:-50EGr2/M:-10E	16RU
7		測定用電源コト'を		抜く	/GET:-50EGr2/M:-10E	16RU

FIG. 45



09753999-010301

FIG. 46

4609 4610

XXXXXXX

☒ ALL ☐ DESIGNATE :

PRODUCT NUMBER: NAME:

PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0 - CLOCK	XXXX	XX	XXXX	XXX
XXXXXX		BL - OLD	SET IN 1996	
xyz - test				
test - 01				
test - AMI				

4601 4611 4602 4603 4604 4605

4612

46/97

095903 010301

FIG. 47

[illegible]

FIG. 48

LOAD OF DATA

COMPONENT DESIGNATION

☐ ALL

☒ DESIGNATE COMPONENT

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4800

4801

4802

4803

4804

4805

4806

FIG. 49

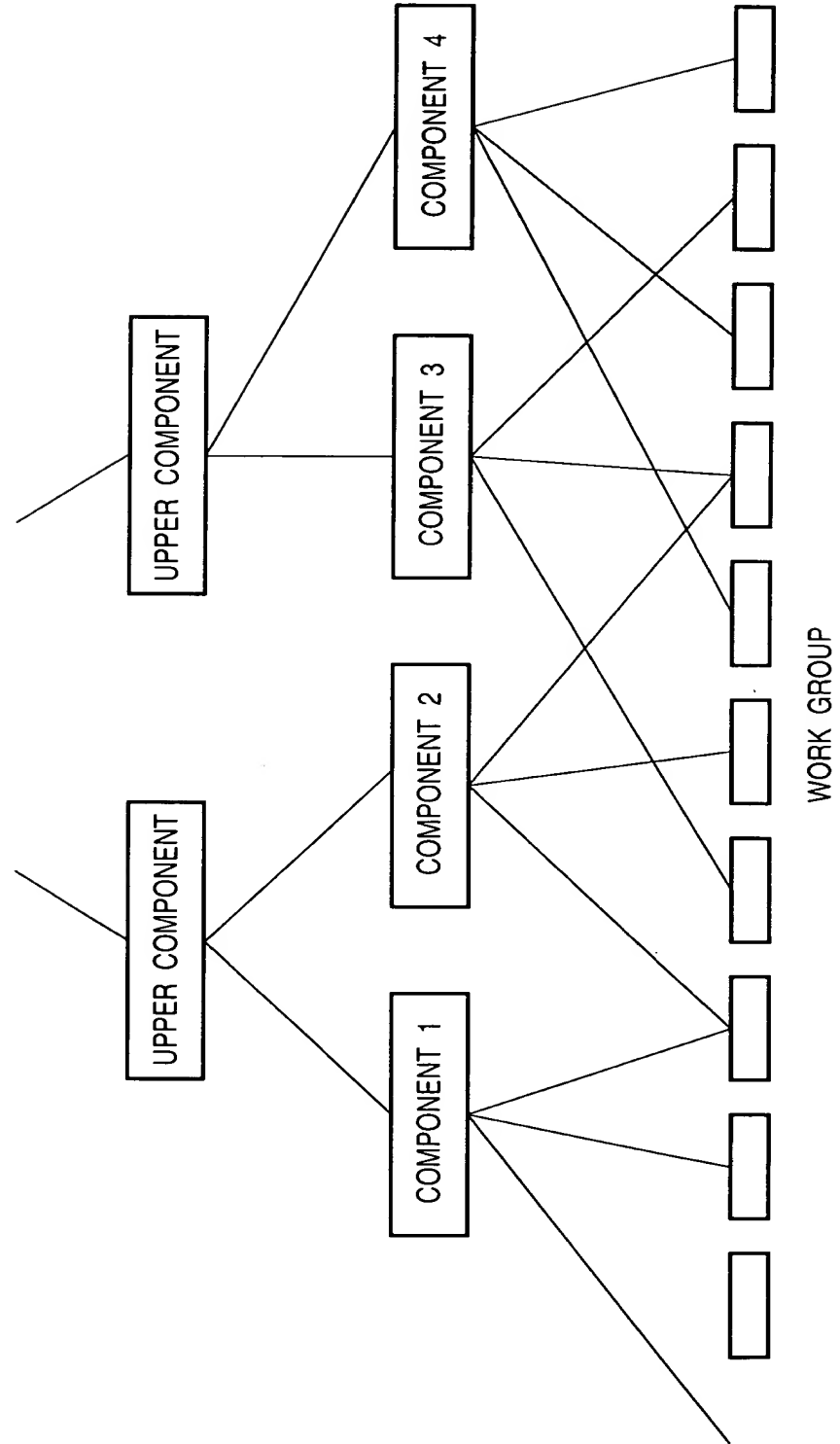


FIG. 50

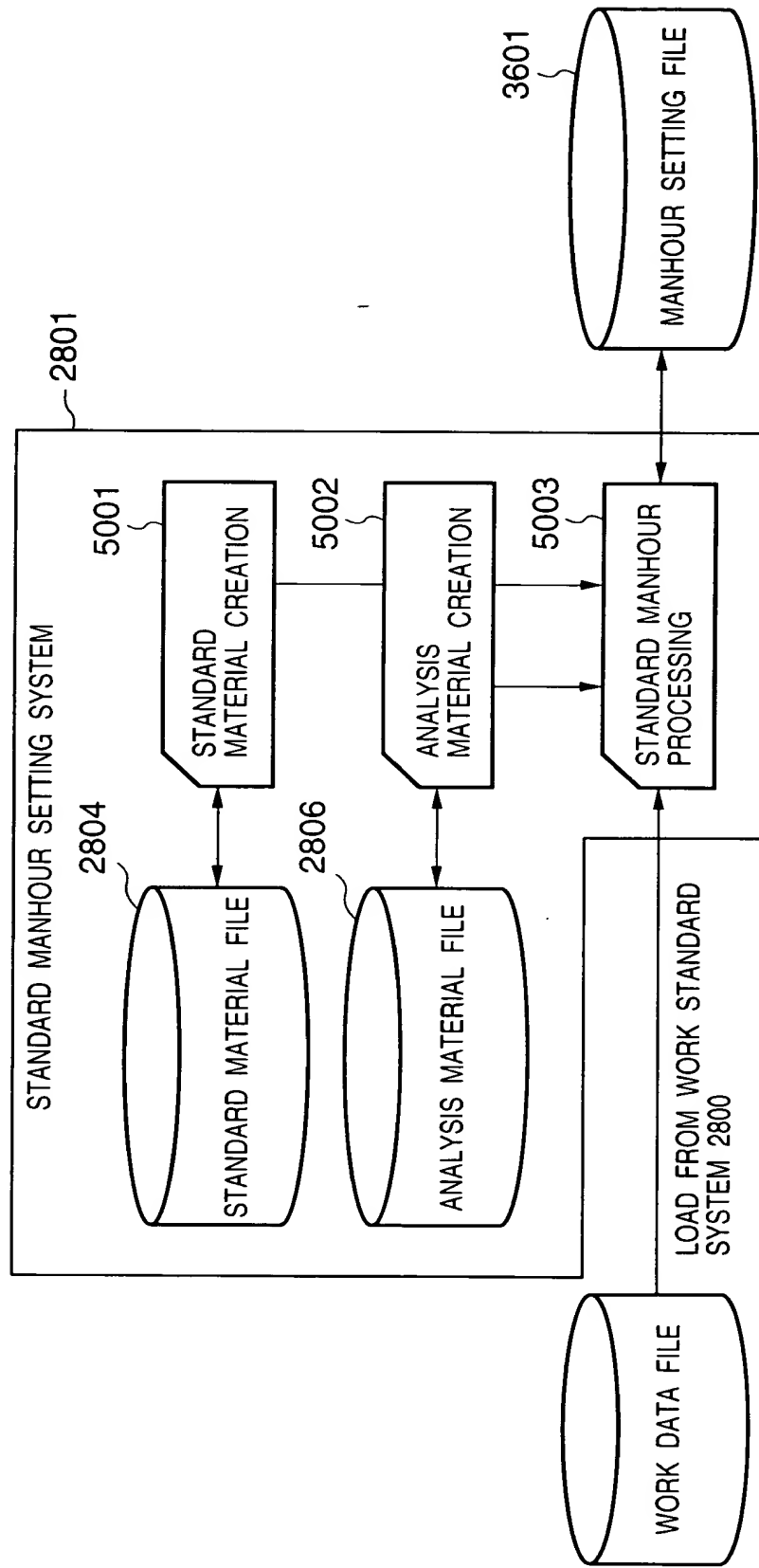


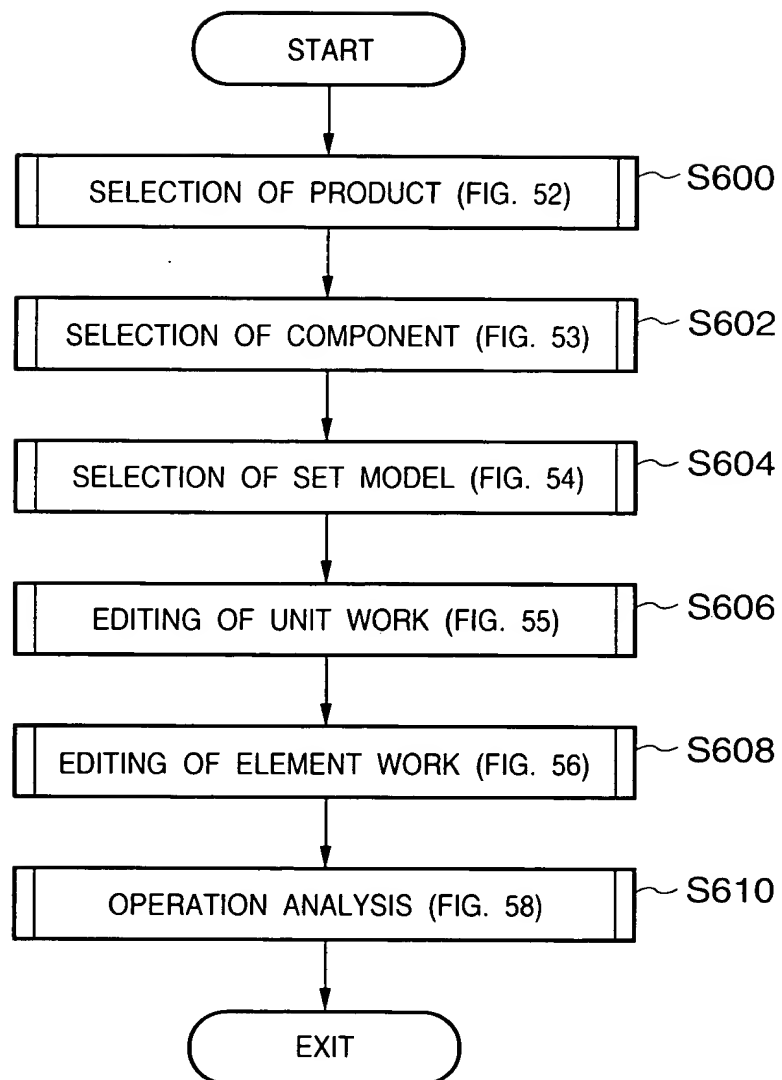
FIG. 51

FIG. 52

SELECTION OF PRODUCT			
FILE(F) EDIT(E)			
PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE	
BJ - 970909	XXXXX	1997/09/22 10:17:30	
BJ - STAND		1997/09/12 15:09:09	
BJ - test	TEST Q1 Standard	1997/09/18 10:38:14	
BJ250	250 TESTS	1997/09/17 17:58:59	
ST01	STAND PRODUCT	1997/09/12 16:02:34	
		1997/09/19 15:46:04	

SET MANHOUR

EXTRACT DATA
CREATE HOST TRANSFER
ANALYZE DATA
END

0975943-010301

0975943-010301

FIG. 54

SELECTION OF MODEL			
FILE(F) EDIT(E) VIEW(V)			
FILE	EDIT	VIEW	
PRODUCT NUMBER : BJ - 970909 NAME : 97 - 09 - 09 LOAD COMPONENT SYMBOL : CH NAME :			
SET MODEL SYMBOL	QUANTITY	NAME	PREVIOUS PUBLICATION DATE
▲ A250 IIQ			
BJC - 4200LX			
BJC - 4200 SYSTEM			
BJC - 420J			
BJC - 420J(BLACK)			
BJC - 4300		XXXXX	1997/09/09 10:46:33
BJC - 430J			

55/97

55/97

FIG. 57

EDITING OF ANALYSIS MATERIAL



FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USE	FREQUENCY	COUNT	SET DATE	
▶	I7-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	1	0	97/09/09 9:52
	I7-キャップ:	本体を	矢印1の様に	入れる	-50/E/02/N/-6	11	0	1	1	0	97/09/09 9:53
	I7-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	1	0	97/09/09 9:55
		要素作業01		動詞	-50/Gr1/N/>6/-3	15	0	1	1	0	97/09/10 16:34
	I7-キャップ:	本体を	矢印1の様に	入れる	-50/Gr1/N/>6/-3	15	0	1	1	0	97/09/10 19:09
		キャリッジ・ロック		塗布する	Time100/Rate100	100	100	1	1	1	97/09/10 19:16
	モーター組立:	フリンダジャーシ		入れ、セツとする	M211/1/10	50	1	1	1	1	97/09/11 17:00
		フリンダジャーシ		裏面にする	T1221/M2311/0/0	12	0	1	1	0	97/09/11 17:34
		1		1	T2221/M1211/0/1	24	0	1	1	0	97/09/11 17:20
		2		2	T1221/M2311/0/0	12	0	1	1	0	97/09/11 17:24
		フリンダジャーシ	PRカ'イト'取付る	セツとする		15	0	1	1	0	97/09/12 11:24
		dgdla/dlas		fdasldasldad	*	16	0	1	1	0	97/09/12 12:10
		dsdsf/sdsdsaf		fsasfdadfdas	T21121/M1111/0/1	13	0	1	1	0	97/09/12 12:10
		dgdla/dlas		fdasldasldad	*	16	0	1	1	0	97/09/12 13:39
		フリンダジャーシ	PRカ'イト'取付る	セツとする		15	0	1	1	0	97/09/12 14:00
		フリンダジャーシ	PRカ'イト'取付る	セツとする		15	0	1	1	0	97/09/12 14:00
		フリンダユニット		セツとする	Time100/Rate100	100	100	1	1	0	97/09/12 14:04

FIG. 58

5801
5802
5803
5804
5805

OPERATION ANALYSIS

📄
🔍
📁
✕
📄
📄

1 SET MAIN BODY TO
PREDETERMINED POSITION

0

TOTAL SIMO VALUE :

15

TOTAL MANHOUR VALUE :

SIMO

NEXT ELEMENT WORK

NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOUR	USE	REMARKS
▲ 1	XXXXXX	PU	-60/Gr1/N/>6/-3	15	0	
*						

▶

58/97

FIG. 59

5901

☐ 1. PU

☐ 2. GET

☐ 3. M

☐ 4. MA

☐ 5. ASY

☐ 6. DSY

☐ 7. R

☐ 8. UMAC

☐ 9. MP

☐ 10. BODY

☐ 11. PU

☐ 12. GET

☐ 13. M

☐ 14. MA

☐ 15. ASY

☐ 16. DSY

☐ 17. R

☐ SIMO

SELECT

CANCEL

5902

FIG. 60

XXXXXX

PU

PICK UP

MANUAL

1 :	MOVING DISTANCE	1	-10cm	2	+10cm	3	>50cm	4	5	6
2 :	GRIP TYPE		Qr-3		Qr-2					
3 :	PRE-POSITIONING		NO		YES					
4 :	MAIN SIZE		-10mm		-6mm					
5 :	WEIGHT		<3Kg		>3Kg					
6 :										

SET

CANCEL

SET VALUE

FORMULA

6001

6002

6003

FIG. 61

FORMULA

TURNCHANGE DIRECTION OF BODYMANUAL

FORMULA : 10 * m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

SET

CANCEL

SET VALUE

6101

6104

6103

6102

6105

FIG. 62

INQUIRY OF LOG

VARIATION AMOUNT : 10

USE : 0

REASON CODE : 1

CHANGE REASON : SET ▼

OK Clear

6201 6202 6203 6204 6205 6206

FIG. 63

6301 6302 63/97

CORRECTION OF CHANGE LOG

DATE 1997 09 22 ○ = ○ FROM ○ BEFORE ○ ~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MANHOUR	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14.30.00

REASON CODE 1 CHANGE REASON SET

OK CIR END

FIG. 64

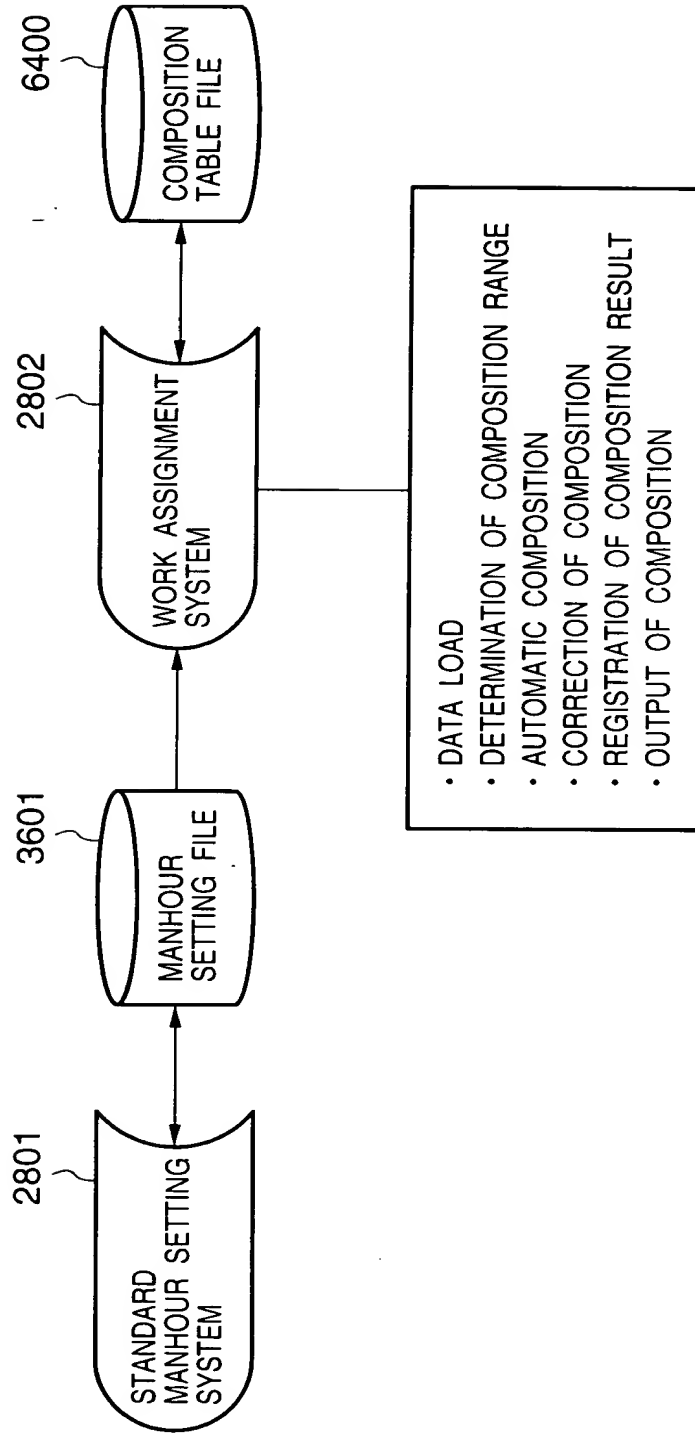


FIG. 65

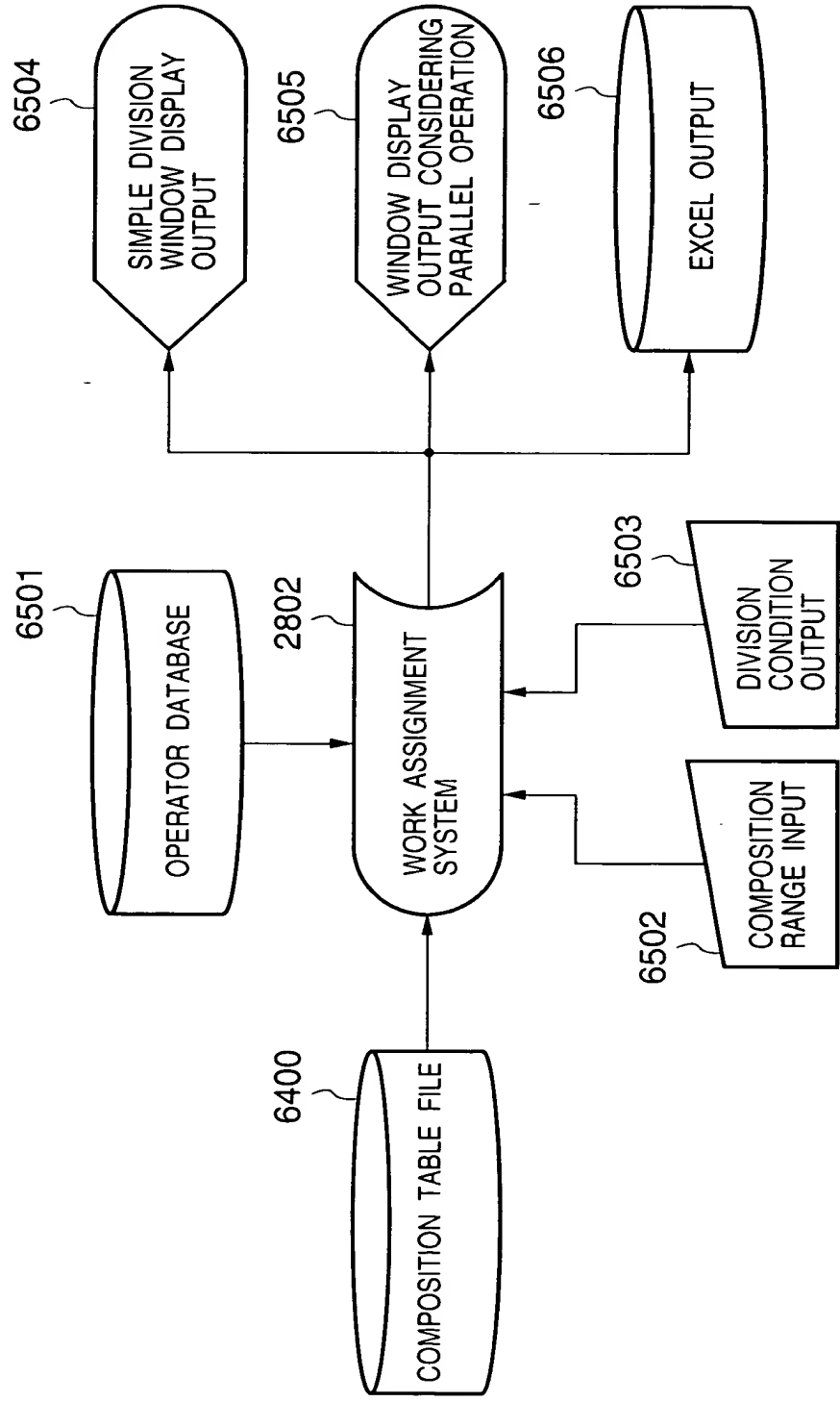


FIG. 66

WORK ORDER

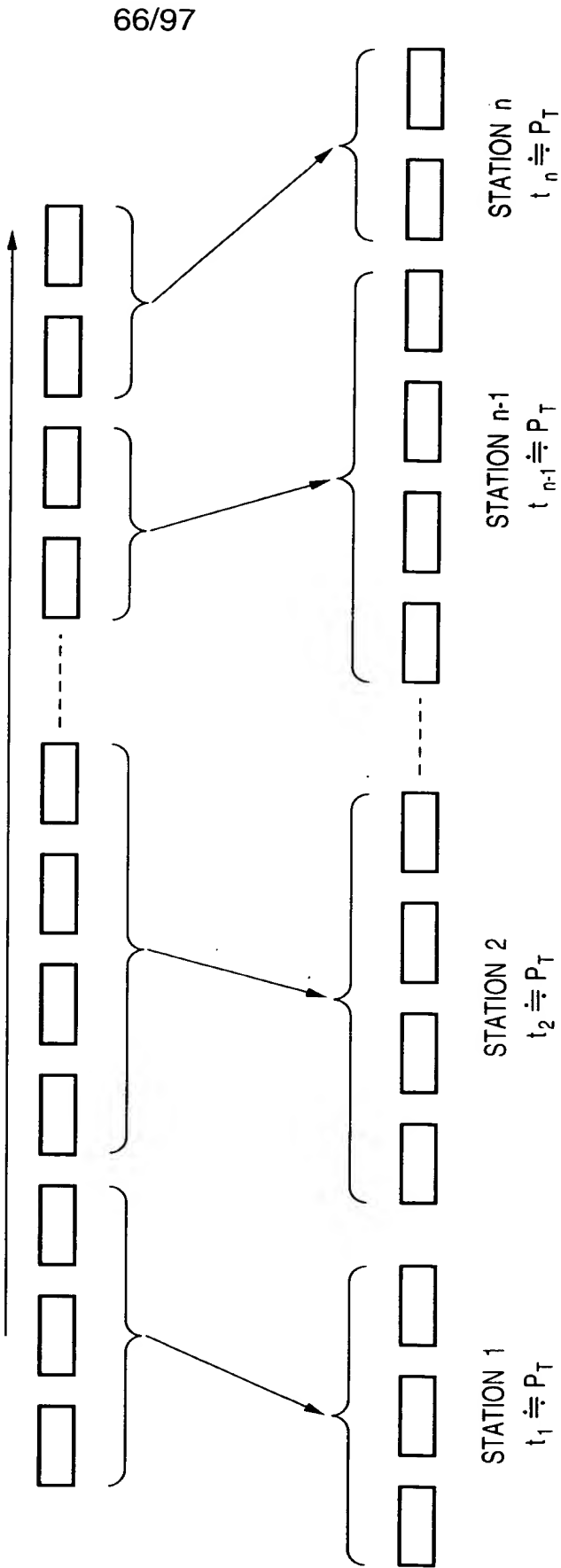


FIG. 67

FILE(F) EDIT(E) INPUT(I) TOOL(O)

MODEL

GP55

UNIT

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

...

SIMPLE DIVISION
PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

—		▼	▲
—	FILE(F) EDIT(E)	◆	

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

⋮

FIG. 69

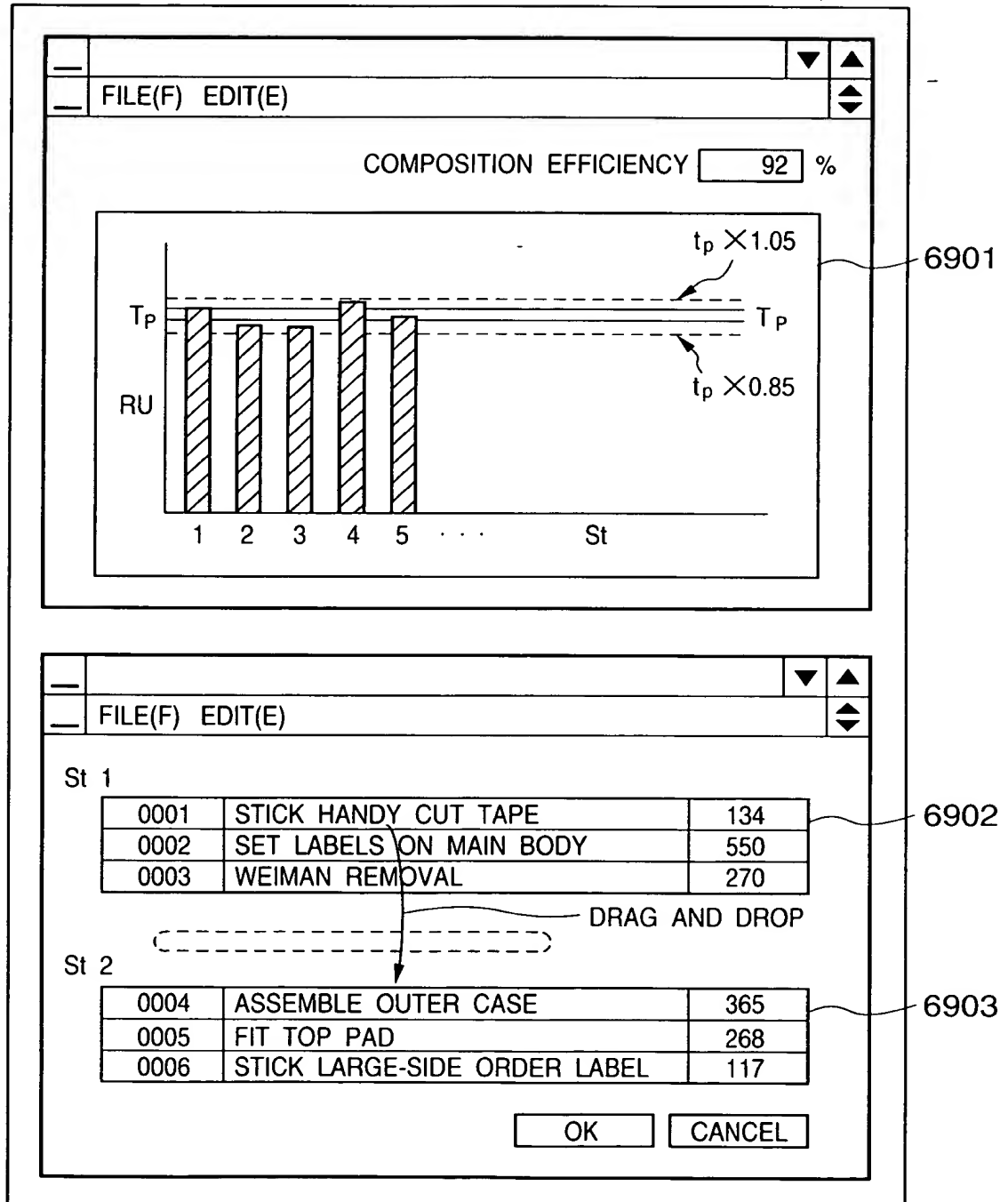
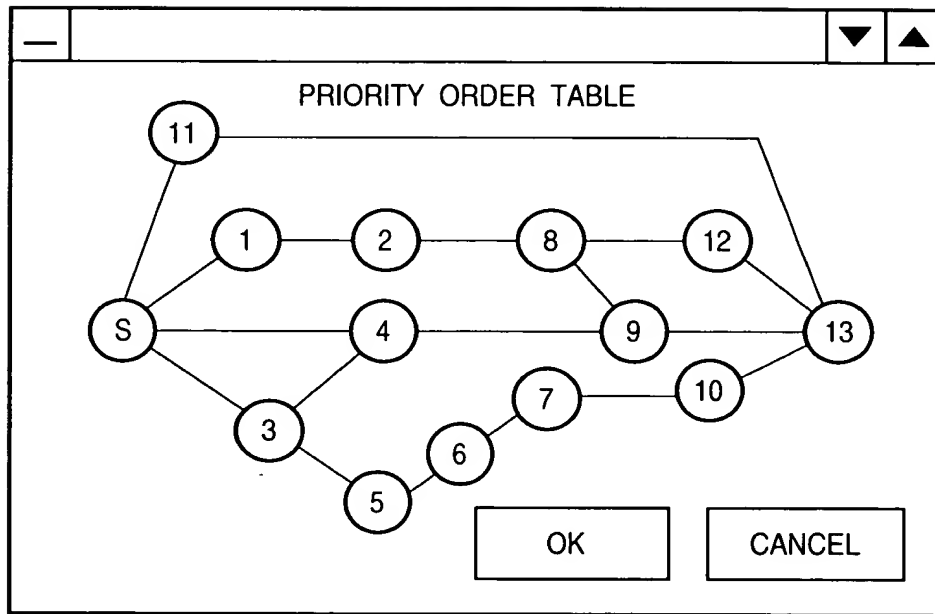


FIG. 70

PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
		⋮			

FIG. 72

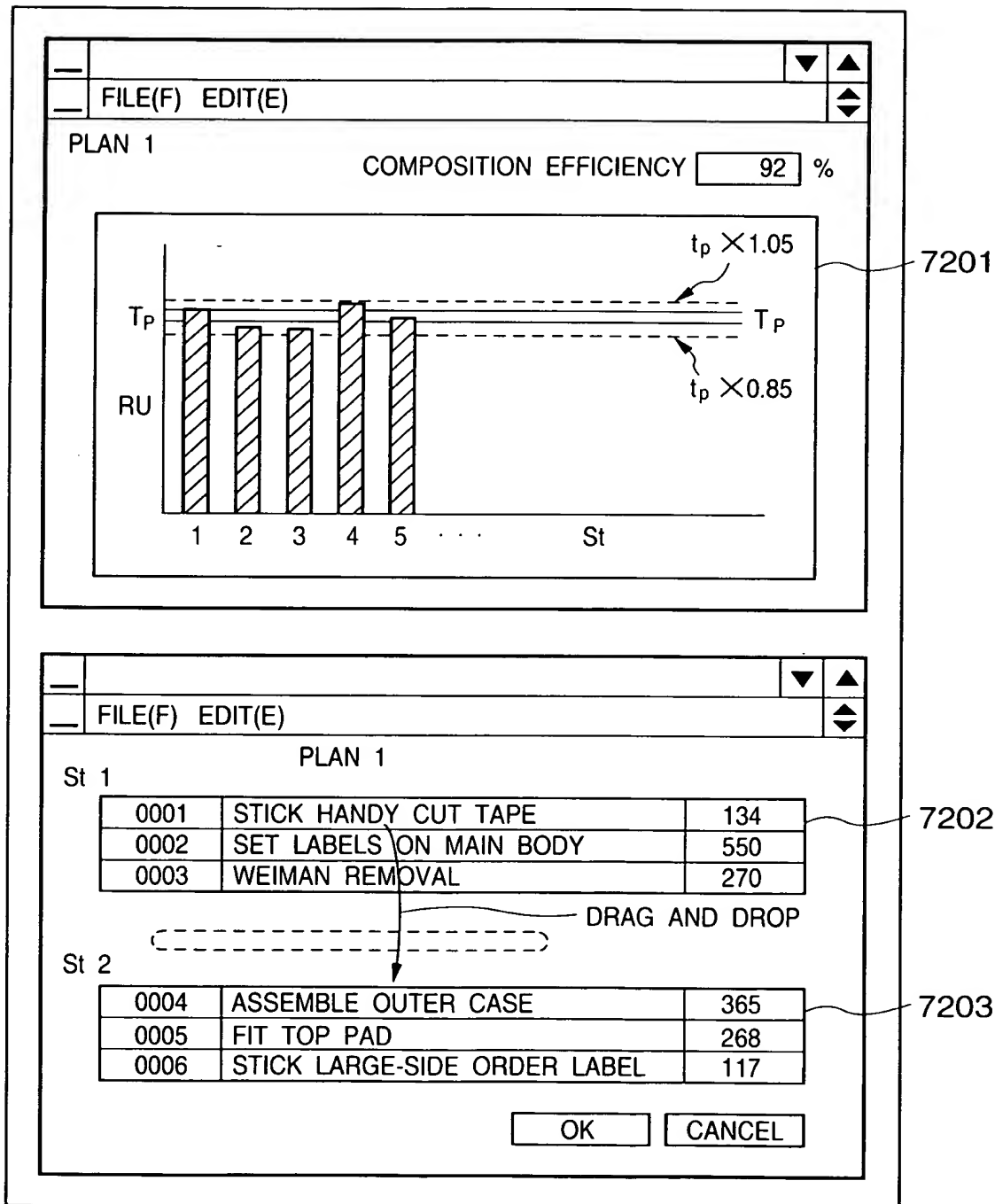


FIG. 73

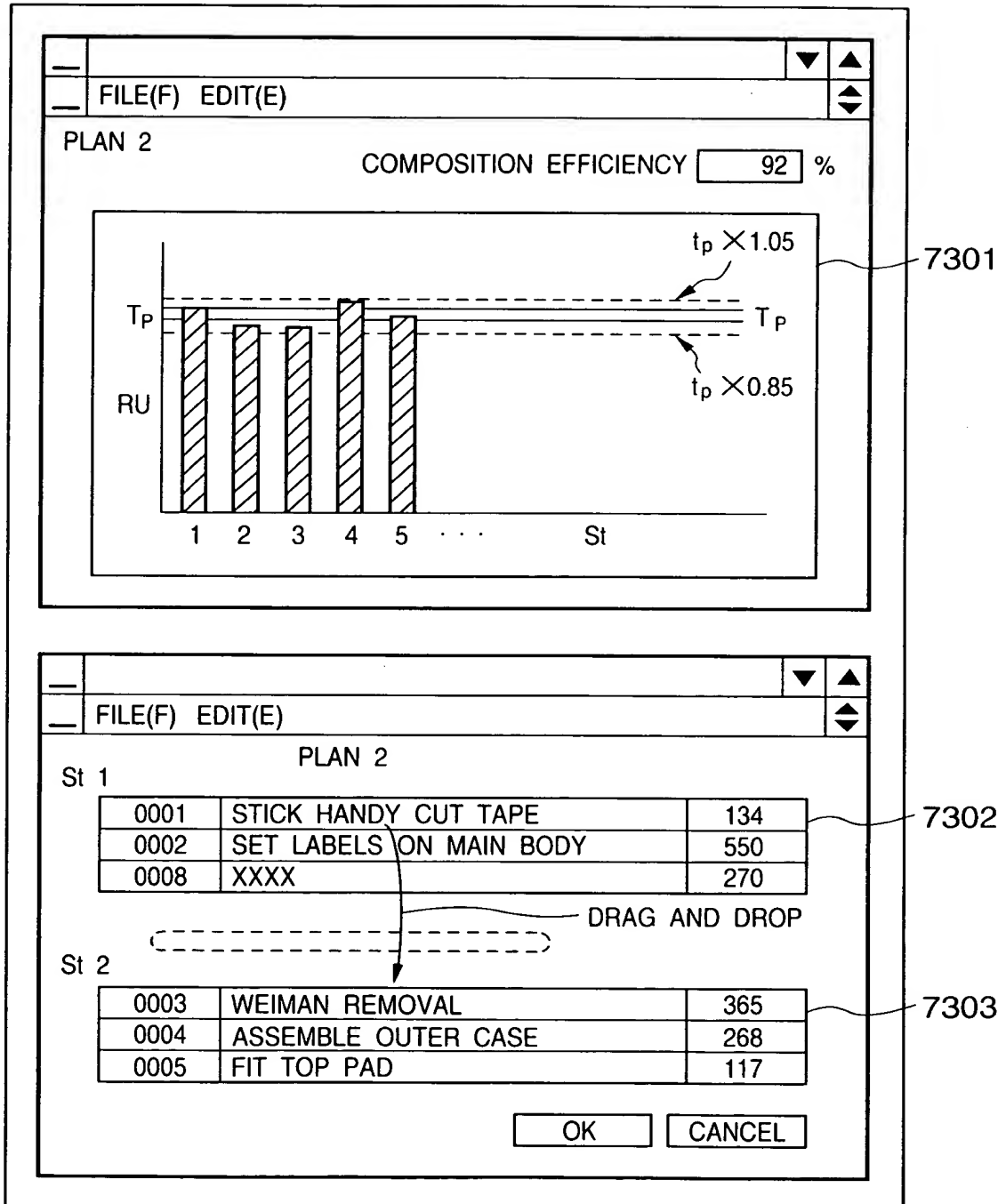


FIG. 75

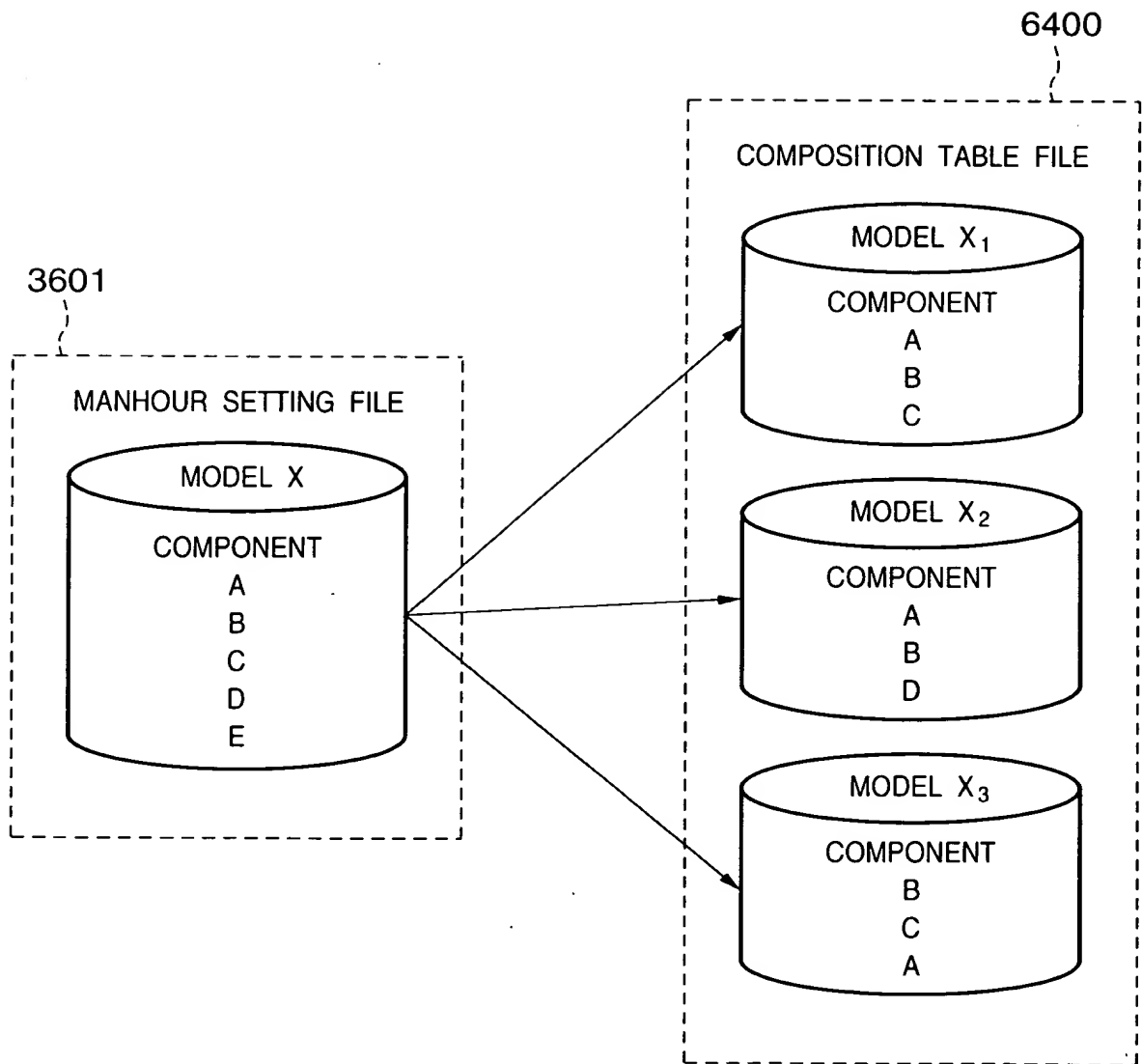


FIG. 76

7601

7602

7603

7604

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

f12-0010.csv	テストデータ(元)	1	97/09/19 12:00:34
f12-0010.csv	テスト	0	97/09/19 13:27:17
BJC-4300	0	0	97/09/19 14:10:14
BJC-4300	0	0	97/09/19 14:10:32
BJC-4300		1	97/09/19 15:41:14
BJC-4300	BJC-4300Aライン編成		97/09/20 14:16:38
BJC-4300	BJC-4300Aライン編成	03	97/10/13 17:54:57
BJC-4300	BJC-4300Aライン編成	00	97/09/20 14:06:36
f12-0010.csv	f12-0010Aライン編成	05	97/09/24 17:11:53

SELECT WINDOW

○ COMPOSITION DATA INPUT WINDOW

○ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

7606

7707

FIG. 78

INSERTION OF UNIT WORK X

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

UNIT WORK NAME :

PROVISIONAL MANHOUR : (RU)

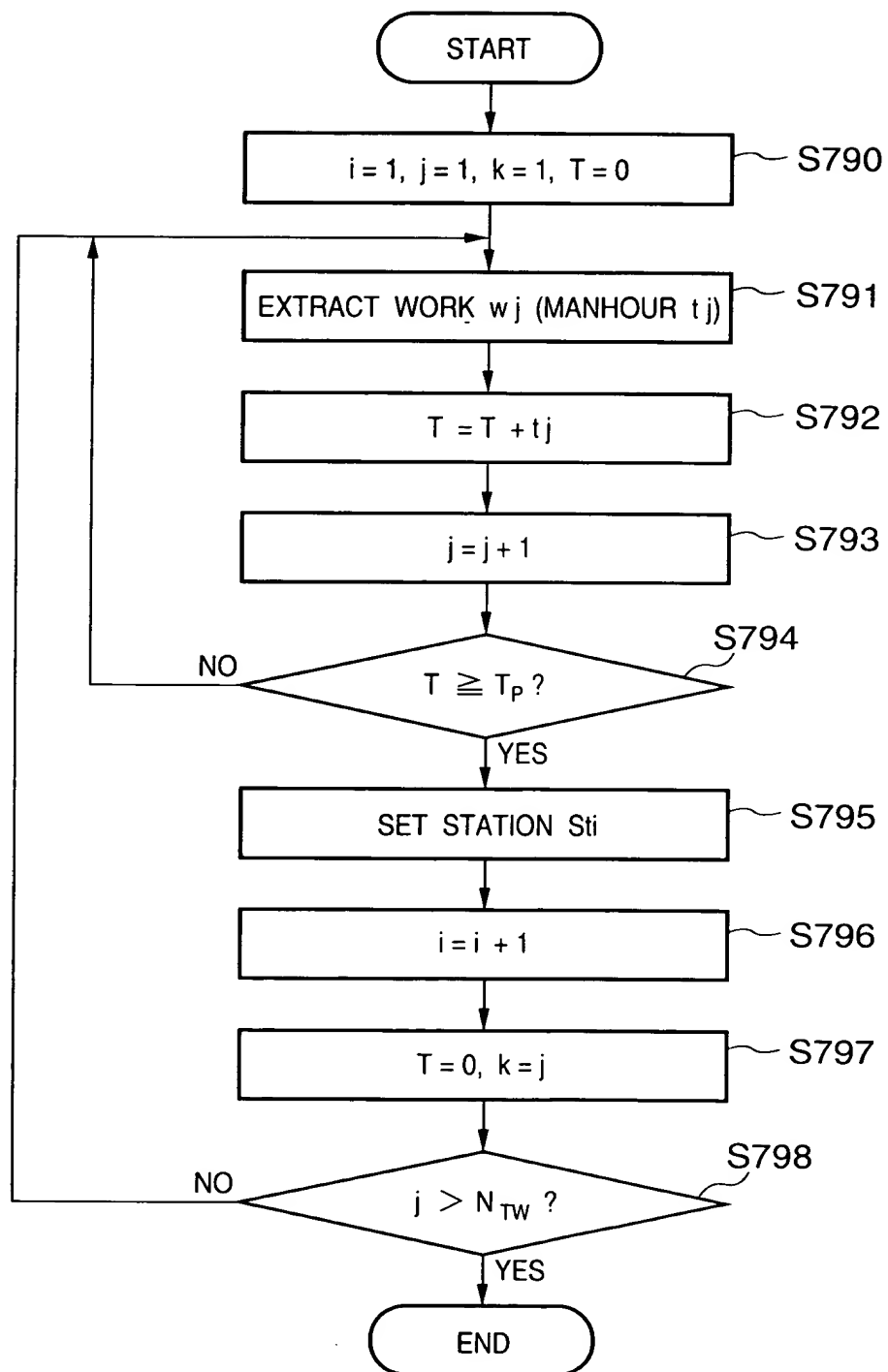
REMARKS :

7801

7802

09753998-010301

FIG. 79



FOOT-8065260

FIG. 80

FILE(E) EDIT(E) VIEW(V) TOOL(T)

8001 OPERATOR 1

8002 OPERATOR 2

8003 OPERATOR 3

8004 OPERATOR 4

8005 OPERATOR 5

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FIG. 81

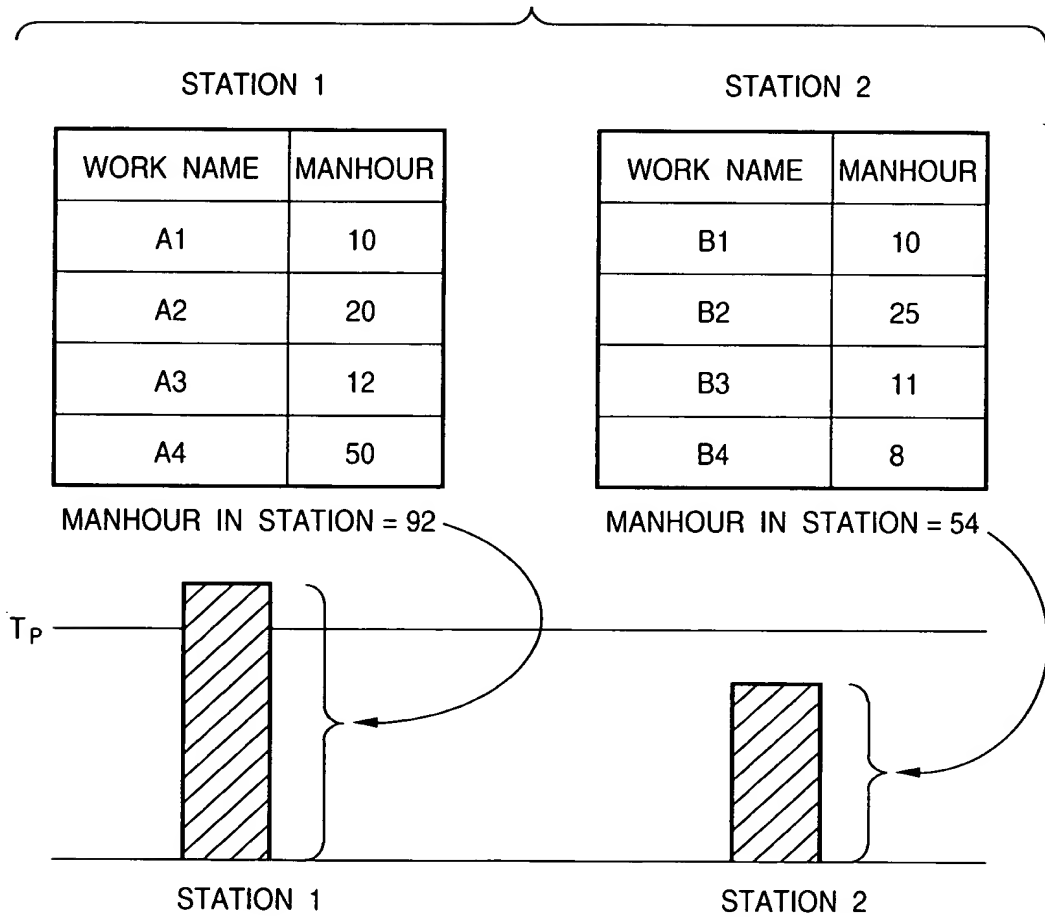


FIG. 82

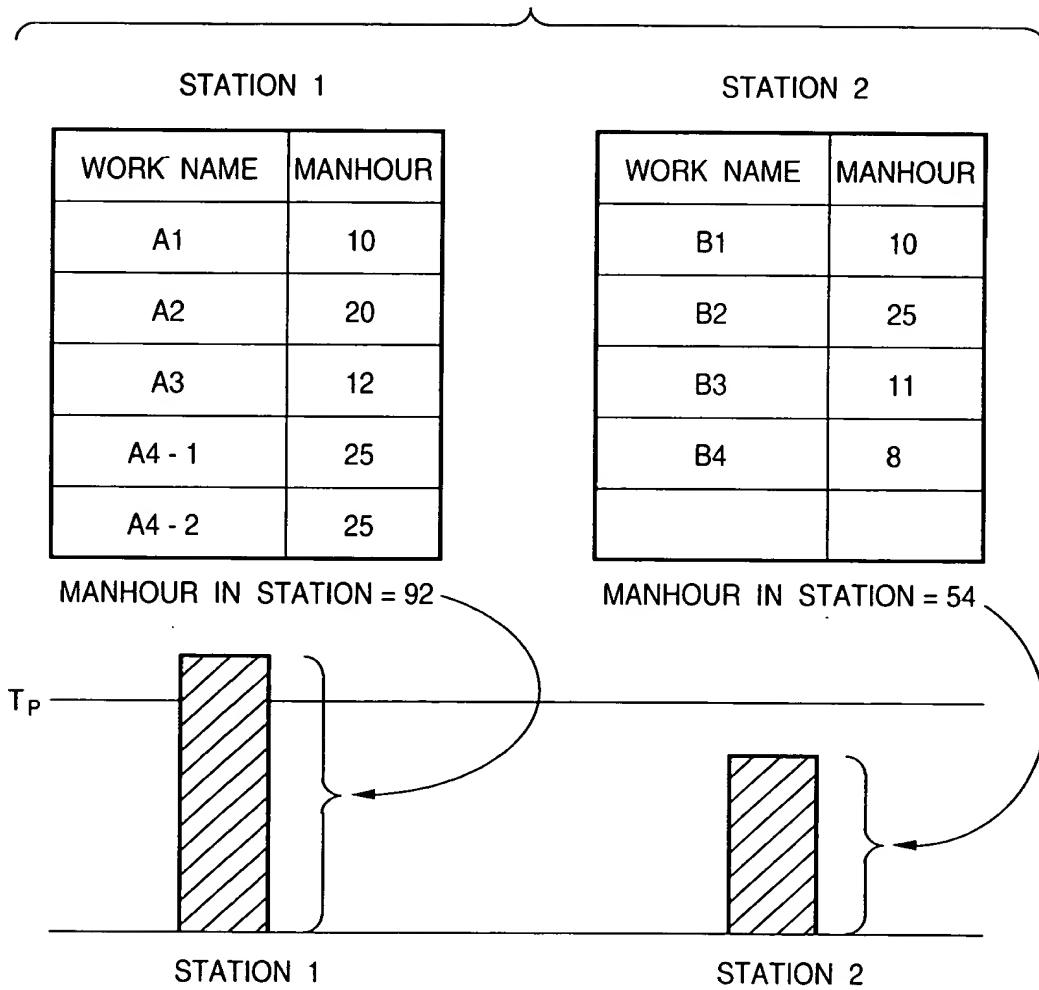


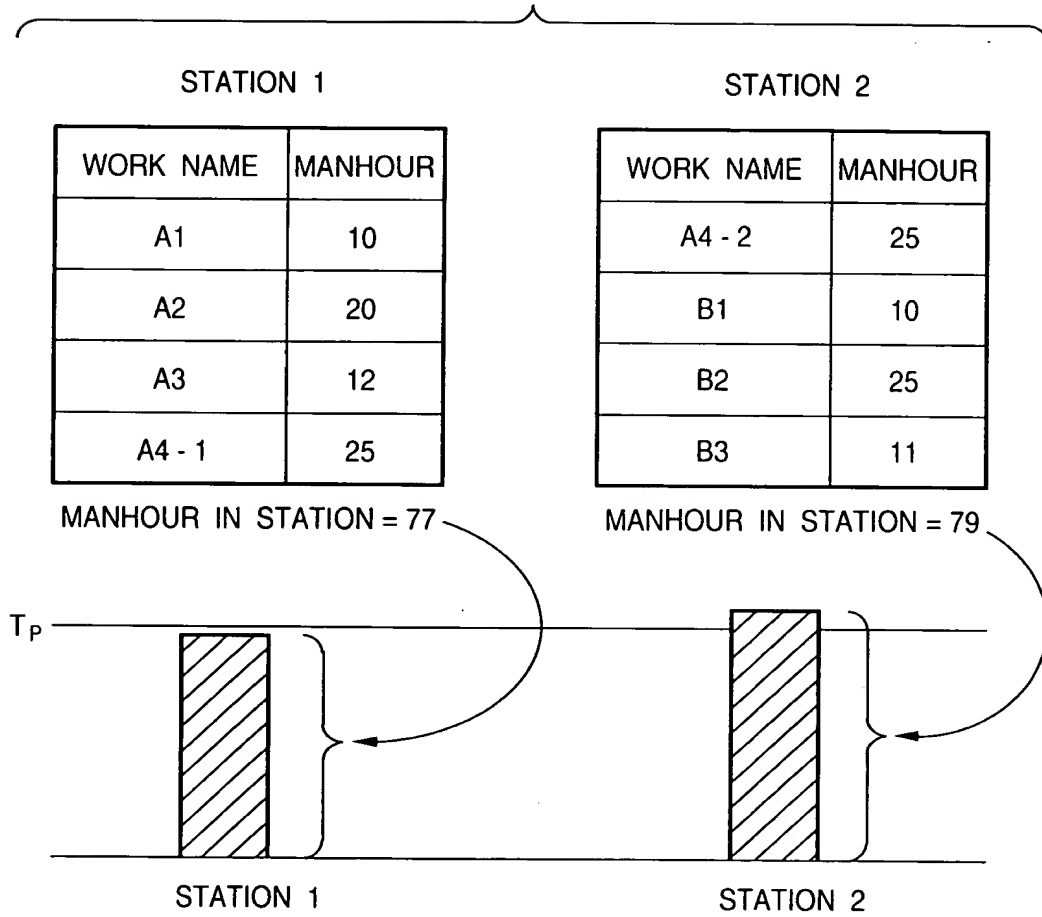
FIG. 83

FIG. 84

PARALLEL OPERATION / INTEGRATION OF STATIONS

TARGET STATION : 1

THE NUMBER OF STATIONS

OK CANCEL

8401 8402

FIG. 85

FILE(E) EDIT(E) VIEW(V) TOOL(T)

X

-

+

OPERATOR 1

S11

WORK NAME	WF	PROV. SIONAL MAN-HOUR	MA-CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 6	92	26	No.06
UNIT WORK NAME 7	52	0	No.07
UNIT WORK NAME 8	52	0	No.08
UNIT WORK NAME 9	0	36	No.09

TOTAL 585 (RU)

OPERATOR 2

S12

WORK NAME	WF	PROV. SIONAL MAN-HOUR	MA-CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.06
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 17	58	20	No.17

TOTAL 1548 (RU) xxxxxx

OPERATOR 3

S13

WORK NAME	WF	PROV. SIONAL MAN-HOUR	MA-CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU)

OPERATOR 4

S14

WORK NAME	WF	PROV. SIONAL MAN-HOUR	MA-CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 623 (RU)

OPERATOR 5

S15

WORK NAME	WF	PROV. SIONAL MAN-HOUR	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

TOTAL 585 (RU)

PF 83.6%

TOTAL 1548 (RU) xxxxxx

PF 23.5%

TOTAL 572 (RU)

PF 96.7%

TOTAL 623 (RU)

PF 95.2%

TOTAL 486 (RU)

PF 73.6%

PARALLEL STATIONS

900	720	540	360	180	0	1	2	3	4	5
<div style="display: flex; justify-content: space-between;"> <div> <p>--- tp</p> <p>--- tp*1.05</p> <p>--- tp*0.85</p> <p>---</p> </div> <div> <p>G STANDARD NO</p> <p>WORK NAME</p> <p>MA-CHINE MAN-HOUR</p> <p>PROVISIONAL REMARKS</p> </div> </div>										

COMPOSITION EFFICIENCY

116 %

NET COMPOSITION EFFICIENCY

%

COMPOSITION MODE: PRIORITY ORDER SCHEME

FIG. 86

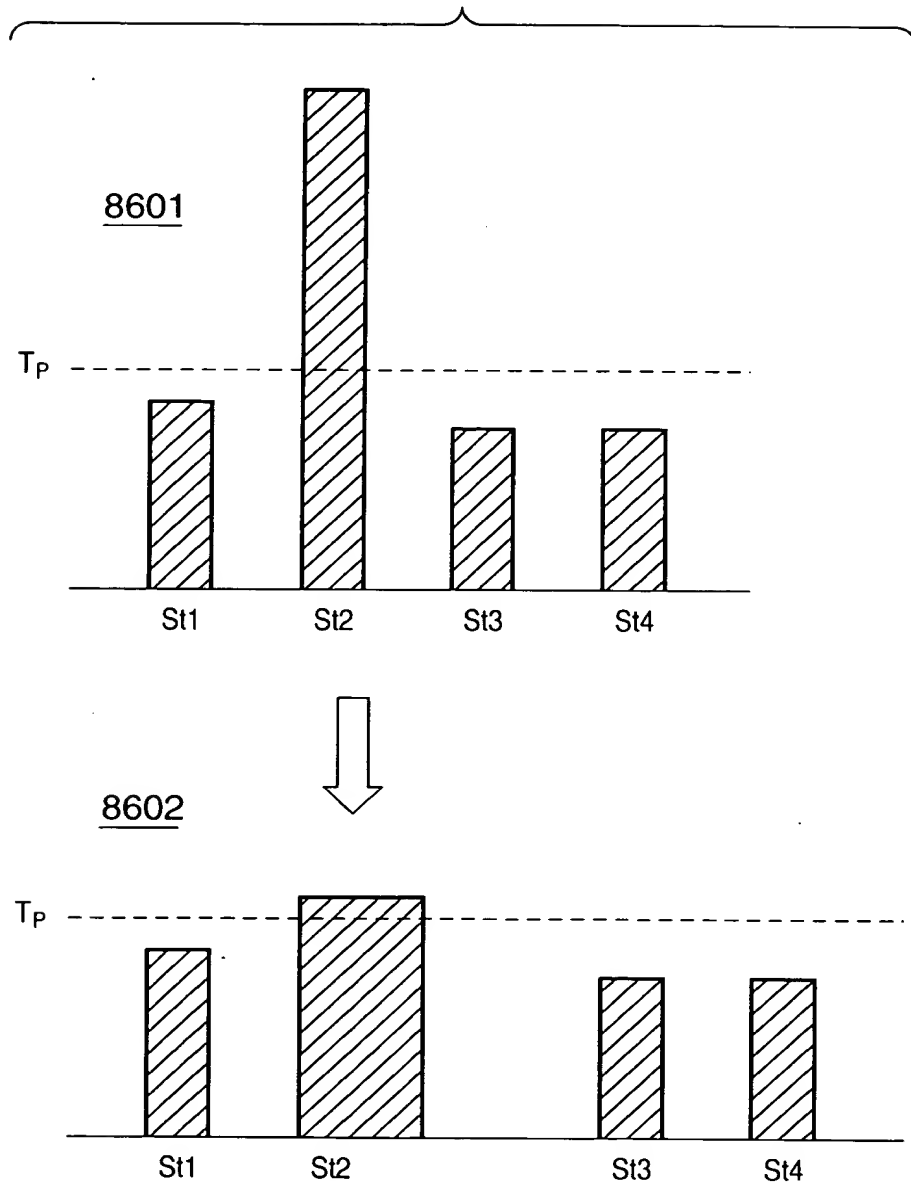


FIG. 87

A diagram of a "USER REGISTRATION" dialog box. The dialog box has a title bar with a close button (X). Inside, there are five input fields with labels to their left: "NAME CODE :", "NAME :", "POSITION :", "PASSWORD :", and "AUTHORITY :". The "NAME" field is split into two boxes containing the Japanese characters "田中" and "一郎". The "POSITION" field is a dropdown menu showing "kumitate". At the bottom are "OK" and "CANCEL" buttons. Five callout lines with numbers 8701 through 8705 point to specific parts of the form: 8701 points to the "NAME CODE" input box, 8702 points to the first "NAME" input box, 8703 points to the "POSITION" dropdown, 8704 points to the "PASSWORD" input box, and 8705 points to the "AUTHORITY" input box.

USER REGISTRATION

NAME CODE : 12345 8701

NAME : 田中 一郎 8702

POSITION : kumitate 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

FIG. 88

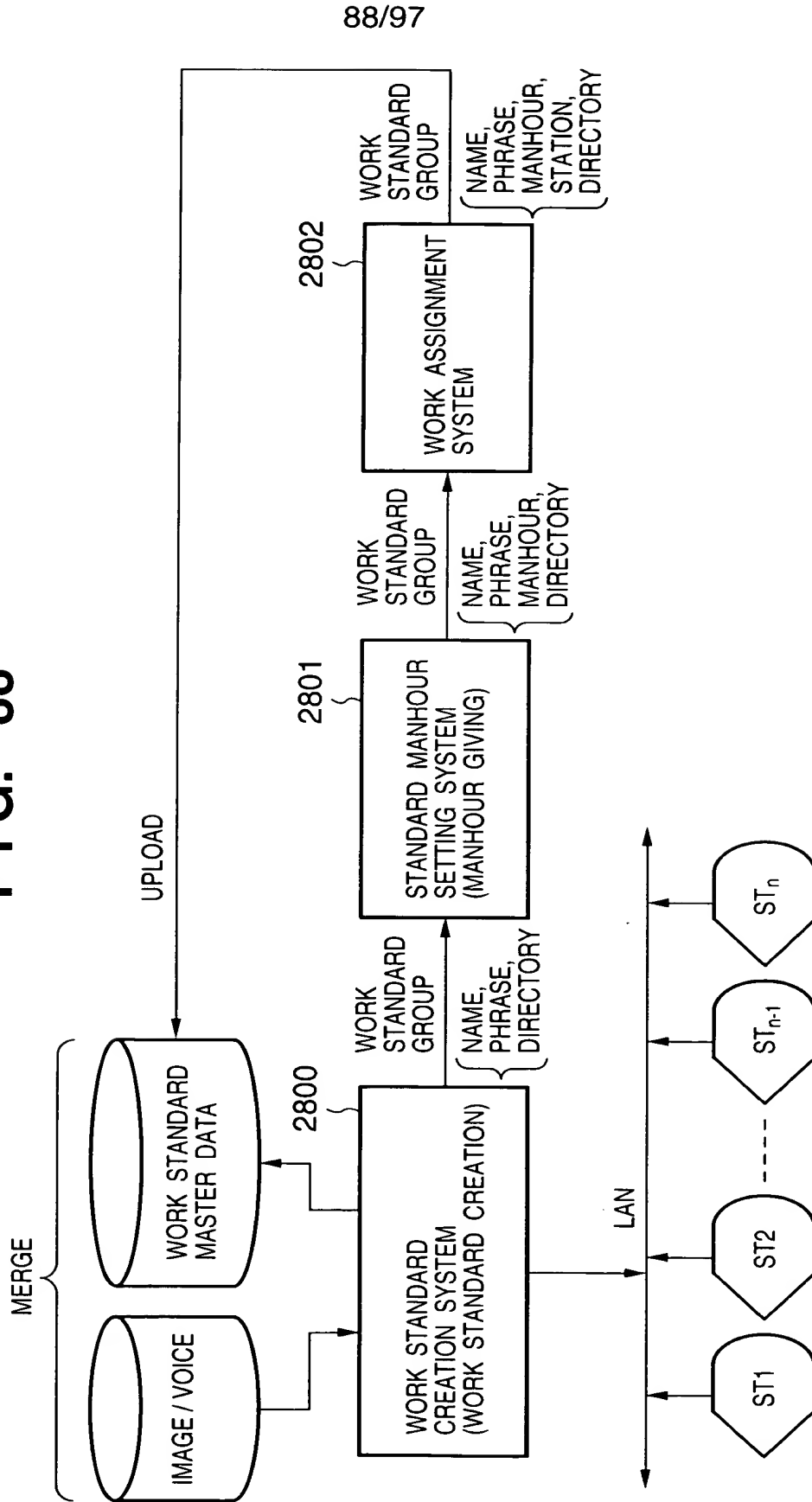
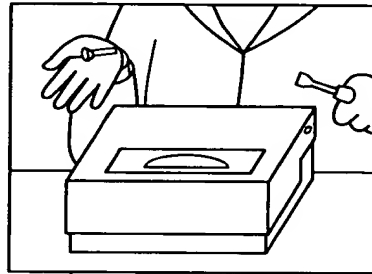


FIG. 89

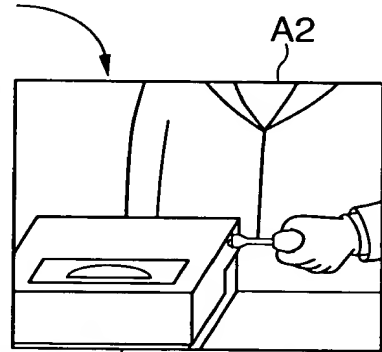
DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

FIG. 90

1. SCREW A

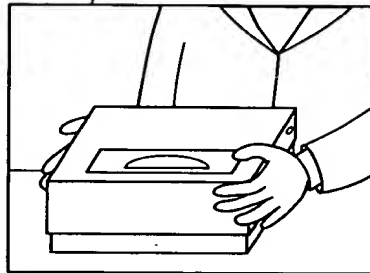


A1

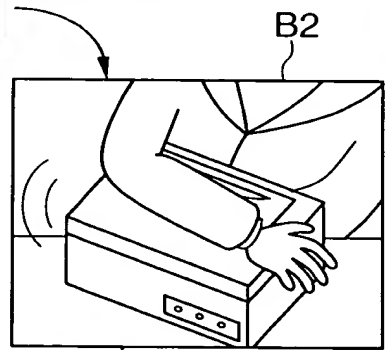


A2

2. ROTATE MAIN BODY

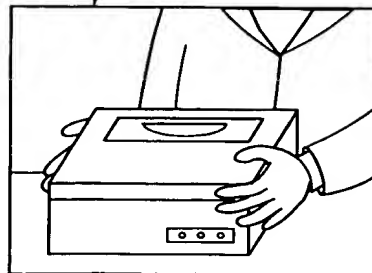


B1

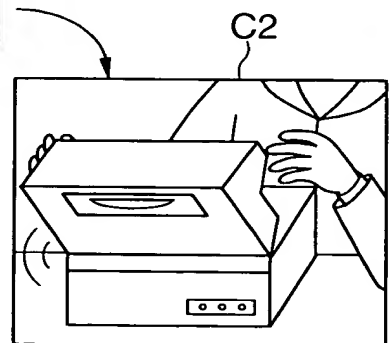


B2

3. OPEN COVER



C1



C2

FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

09753998-010301

FIG. 92

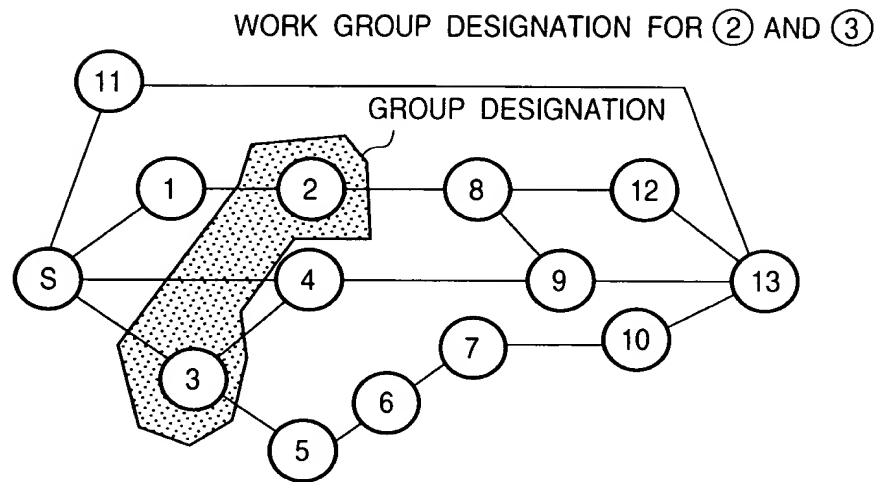
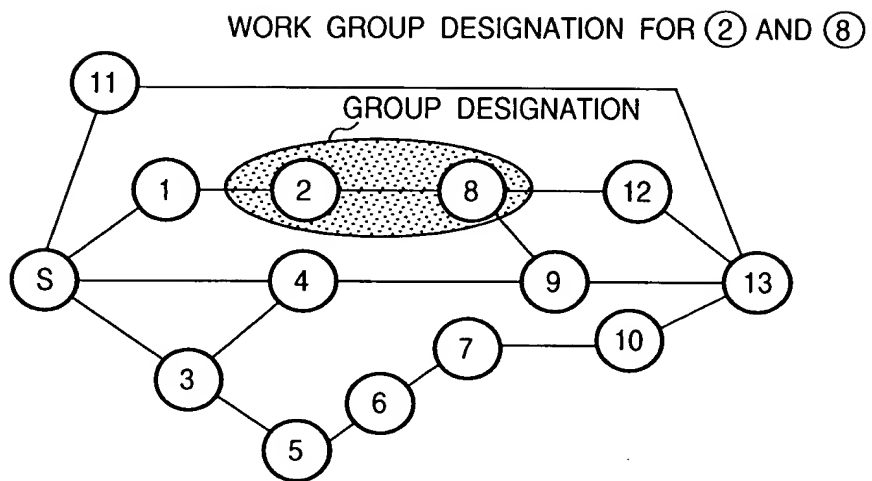


FIG. 93



09753998-010301
T0E0T0-866E5Z60

FIG. 94

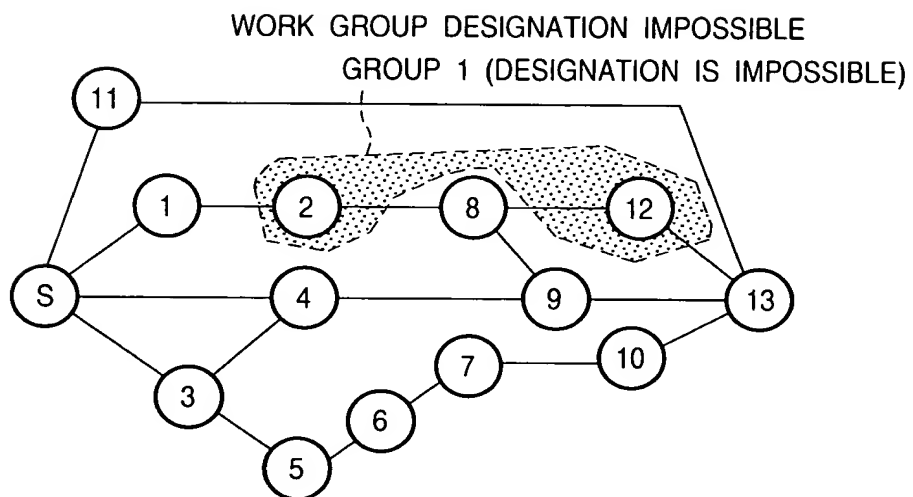
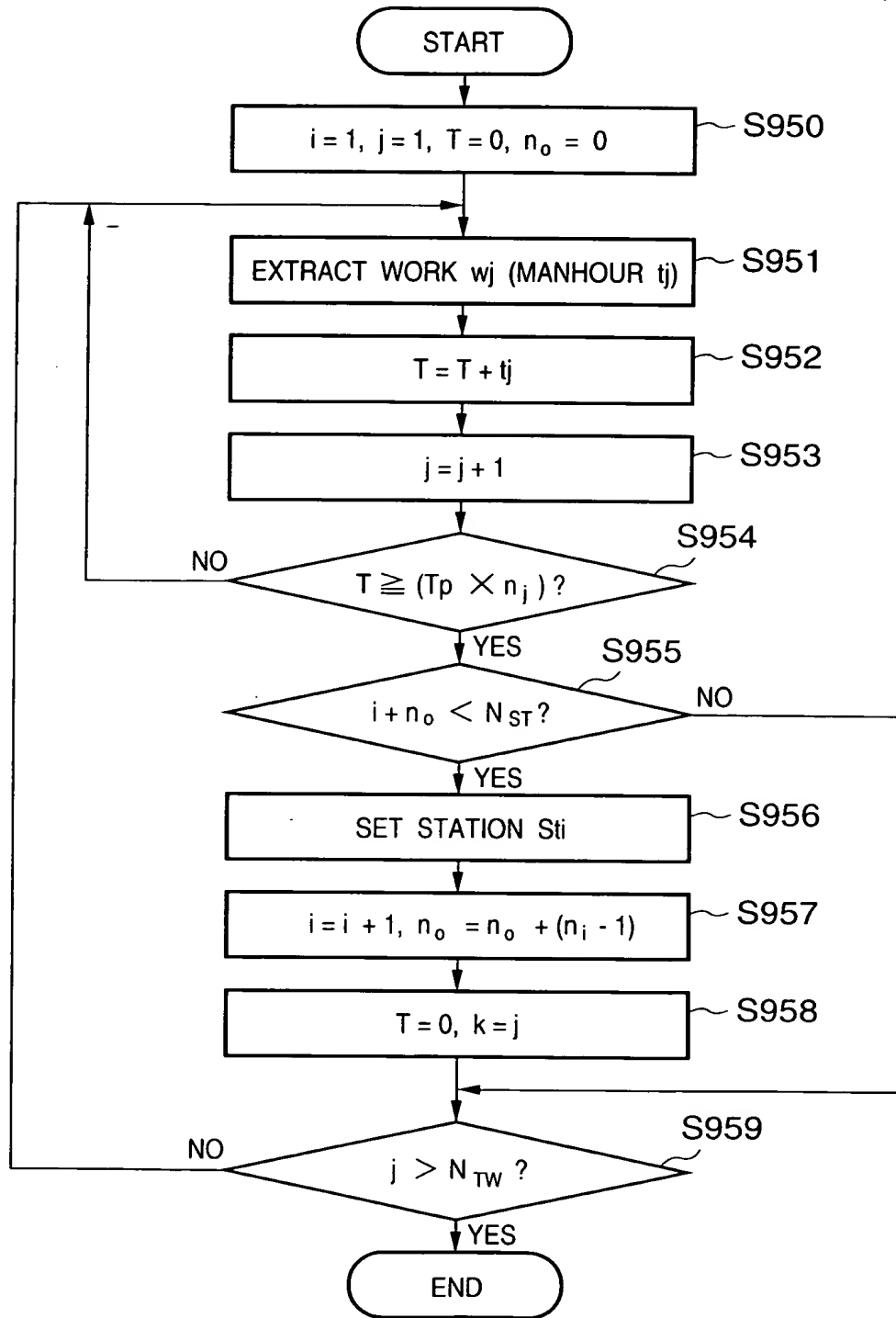


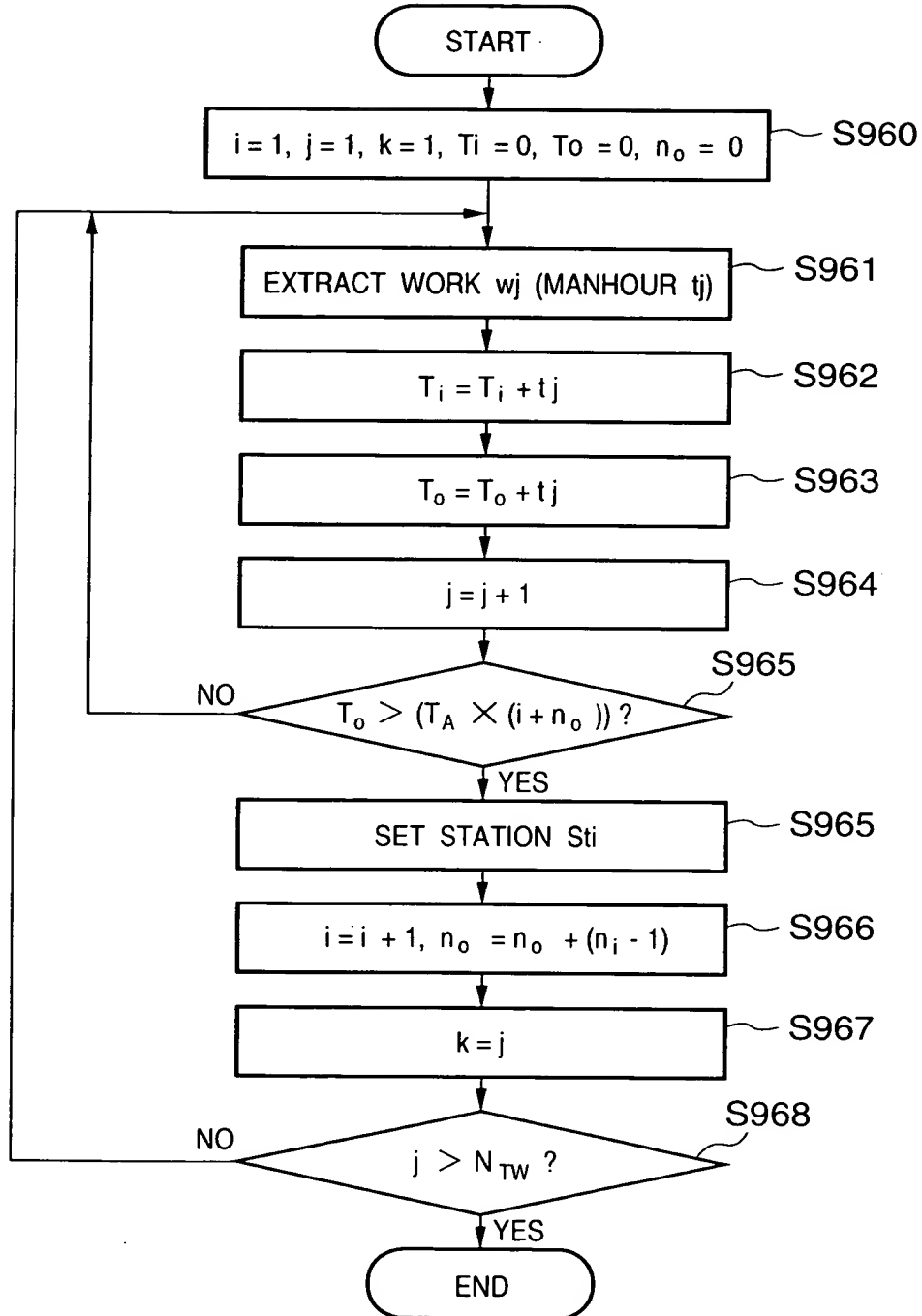
FIG. 95



N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

96/97

FIG. 96



N_{ST} : THE NUMBER OF STATIONS
 T_i : i STATION MANHOUR
 T_A : STATION MANHOUR AVERAGE VALUE
 $T_A = WF / N_{ST}$
 T_o : TOTAL ACCUMULATED MANHOUR
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FOR "8665260"

T0000"866ES.60

FIG. 97

FILE(E) EDIT(E) VIEW(V) TOOL(T)																																																																																																																																									
<div> <div>OPERATOR 1</div> <div>OPERATOR 2</div> <div>OPERATOR 3</div> <div>OPERATOR 4</div> <div>OPERATOR 5</div> <div>OPERATOR 6</div> </div>																																																																																																																																									
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